

FORM PTO 1390
(REV 5-93)

US DEPARTMENT OF COMMERCE PATENT AND TRADEMARK OFFICE

ATTORNEY DOCKET NUMBER
2001_1736ATRANSMITTAL LETTER TO THE UNITED STATES
DESIGNATED/ELECTED OFFICE (DO/EO/US)
CONCERNING A FILING UNDER 35 U.S.C. §371U.S. APPLICATION NO.
(if known, see 37 CFR 1.5)
NEW 097980578International Application No.
PCT/JP00/03456International Filing Date
May 29, 2000Priority Date Claimed
June 2, 1999**Title of Invention**

PROCESSES FOR THE PREPARATION OF NOVEL SUBSTITUTED PROPENONE DERIVATIVES

Applicant(s) For DO/EO/US

Masaaki UENAKA, Kyoza KAWATA, Masahiko NAGAI and Takeshi ENDOH

Applicant herewith submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information:

1. ☒ This is a **FIRST** submission of items concerning a filing under 35 U.S.C. §371.
2. ☐ This is a **SECOND** or **SUBSEQUENT** submission of items concerning a filing under 35 U.S.C. §371.
3. ☐ This express request to begin national examination procedures (35 U.S.C. §371(f)) at any time rather than delay examination until the expiration of the applicable time limit set in 35 U.S.C. §371(b) and PCT Articles 22 and 39(1).
4. ☒ A proper Demand for International Preliminary Examination was made by the 19th month from the earliest claimed priority date.
5. ☒ A copy of the International Application as filed (35 U.S.C. §371(c)(2))
 - a. ☐ is transmitted herewith (required only if not transmitted by the International Bureau).
 - b. ☒ has been transmitted by the International Bureau.
 - c. ☐ is not required, as the application was filed in the United States Receiving Office (RO/US)
6. ☒ A translation of the International Application into English (35 U.S.C. §371(c)(2)). **ATTACHMENT A**
7. ☐ Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. §371(c)(3)).
 - a. ☐ are transmitted herewith (required only if not transmitted by the International Bureau).
 - b. ☐ have been transmitted by the International Bureau.
 - c. ☐ have not been made; however, the time limit for making such amendments has NOT expired.
 - d. ☐ have not been made and will not be made.
8. ☐ A translation of the amendments to the claims under PCT Article 19.
9. ☒ An executed oath or declaration of the inventor(s) (35 U.S.C. §371(c)(4)). **ATTACHMENT B**
10. ☐ A translation of the annexes to the International Preliminary Examination Report under PCT Article 36 (35 U.S.C. §371(c)(5)).

Items 11. to 14. below concern other document(s) or information included:

11. ☐ An Information Disclosure Statement under 37 CFR 1.97 and 1.98.
12. ☒ An assignment document for recording. A separate cover sheet in compliance with 37 CFR 3.28 and 3.31 is included.


ATTACHMENT C

13. ☒ A **FIRST** preliminary amendment. **ATTACHMENT D**
☐ A **SECOND** or **SUBSEQUENT** preliminary amendment.

14. ☐ Other items or information:

THE COMMISSIONER IS AUTHORIZED
TO CHARGE ANY DEFICIENCY IN THE
FEE FOR THIS PAPER TO DEPOSIT
ACCOUNT NO. 23-0975.

U.S. APPLICATION NO. 09/980578 NEW		INTERNATIONAL APPLICATION NO. PCT/JP00/03456		ATTORNEY'S DOCKET NO. 2001 1736A	
15. [X] The following fees are submitted BASIC NATIONAL FEE (37 CFR 1.492(a)(1)-(5)): Neither international preliminary examination fee nor international search fee paid to USPTO and International Search Report not prepared by the EPO or JPO \$1040.00 International Search Report has been prepared by the EPO or JPO \$ 890.00 International preliminary examination fee not paid to USPTO but international search paid to USPTO \$ 740.00 International preliminary examination fee paid to USPTO but claims did not satisfy provisions of PCT Article 33(1)-(4) \$ 690.00 International preliminary examination fee paid to USPTO and all claims satisfied provisions of PCT Article 33(1)-(4) \$ 100.00 ENTER APPROPRIATE BASIC FEE AMOUNT =				CALCULATIONS	PTO USE ONLY
Surcharge of \$130.00 for furnishing the oath or declaration later than [] 20 [] 30 months from the earliest claimed priority date (37 CFR 1.492(e)).				\$	
Claims	Number Filed	Number Extra	Rate		
Total Claims	59 -20 =	39	X \$18.00	\$702.00	
Independent Claims	9 - 3 =	6	X \$84.00	\$504.00	
Multiple dependent claim(s) (if applicable)			+ \$280.00	\$280.00	
TOTAL OF ABOVE CALCULATIONS =				\$2,376.00	
[] Small Entity Status is hereby asserted. Above fees are reduced by 1/2.				\$	
SUBTOTAL =				\$2,376.00	
Processing fee of \$130.00 for furnishing the English translation later than [] 20 [] 30 months from the earliest claimed priority date (37 CFR 1.492(f)).				+	\$
TOTAL NATIONAL FEE =				\$2,376.00	
Fee for recording the enclosed assignment (37 CFR 1.21(h)). The assignment must be accompanied by an appropriate cover sheet (37 CFR 3.28, 3.31). \$40 per property +				\$40.00	
TOTAL FEES ENCLOSED =				\$2,416.00	
				Amount to be refunded	\$
				Amount to be charged	\$
a. [X] A check in the amount of \$2,416.00 to cover the above fees is enclosed. A duplicate copy of this form is enclosed. b. [] Please charge my Deposit Account No. 23-0975 in the amount of \$_____ to cover the above fees. A duplicate copy of this sheet is enclosed. c. [] The Commissioner is hereby authorized to charge any additional fees which may be required, or credit any overpayment to Deposit Account No. 23-0975.					
NOTE: Where an appropriate time limit under 37 CFR 1.494 or 1.495 has not been met, a petition to revive (37 CFR 1.137(a) or (b)) must be filed and granted to restore the application to pending status.					

19. CORRESPONDENCE ADDRESS <div style="text-align: center;">  000513 PATENT/TRADEMARK OFFICE </div>	By: <u>Warren M. Cheek, Jr.</u> Warren M. Cheek, Jr., Registration No. 33,367 WENDEROTH, LIND & PONACK, L.L.P. 2033 "K" Street, N.W., Suite 800 Washington, D.C. 20006-1021 Phone: (202) 721-8200 Fax: (202) 721-8250 December 3, 2001
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IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re application of :
Masaaki UENAKA et al. : Attn: BOX PCT
Serial No. NEW : Docket No. 2001_1736A
Filed December 3, 2001 :

PROCESSES FOR THE PREPARATION OF NOVEL
SUBSTITUTED PROPENONE DERIVATIVES
[Corresponding to PCT/JP00/03456
Filed May 29, 2000]

PRELIMINARY AMENDMENT

Assistant Commissioner for Patents,
Washington, DC 20231

Sir:

Prior to calculating the filing fee, please amend the above-identified application as follows:

IN THE SPECIFICATION

Page 1, immediately after the title, please insert:

This application is a 371 of PCT/JP00/03456 filed May 29, 2000.

IN THE FIGURES

Please replace Figures 2, 5 and 9 of the English translation of the international application as originally filed, submitted herewith as Attachment A, with the attached substitute sheets for Figures 2, 5 and 9.

IN THE CLAIMS

Please add the following new claims:

40.(New) The process according to claim 2 which comprises precipitating a complex of a compound of the formula (III-1) and a Lewis acid.

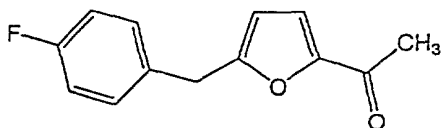
41.(New) The process according to claim 3 wherein a Lewis acid is zinc chloride, stannic chloride or ferric chloride.

42.(New) The process according to any one of claims 2, 3, 40 or 41 wherein R^3 is methyl.

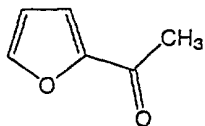
43.(New) The process according to any one of claims 2, 3, 40-42 wherein R^1 and R^2 each is hydrogen.

44.(New) The process according to any one of claims 2, 3, 40-43 wherein R^4 is 4-fluoro.

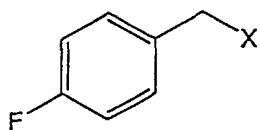
45.(New) A process for the preparation of a compound of the formula:



which comprises reacting a compound of the formula:



with a compound of the formula:

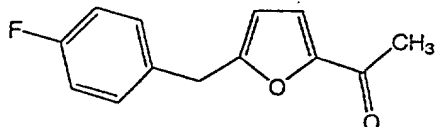


wherein X is halogen,

in the presence of a Lewis acid.

46.(New) The process according to claim 45 wherein a reaction solvent is methylene chloride.

47.(New) The process according to claim 46 which comprises precipitating a complex of a compound of the formula:



and a Lewis acid.

48.(New) The process according to claim 45 wherein a reaction solvent is water.

49.(New) The process according to claim 48 wherein a Lewis acid is zinc chloride, stannic chloride or ferric chloride.

REMARKS

The specification has been amended to reflect the 371 status.

Figures 2, 5 and 9 are replaced with substitute sheets, corresponding to the substitute sheets submitted during prosecution of the original international application.

In addition, new claims 40-49 are added corresponding to the same new claims presented during prosecution of the international application.

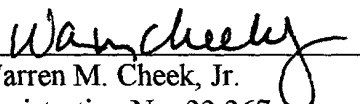
Attached hereto is a marked-up version of the changes made to the specification by the current amendment. The attached page is captioned "**Version with markings to show changes made**".

Favorable action on the merits is solicited.

Respectfully submitted,

Masaaki UENAKA et al.

By


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Attorney for Applicants

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December 3, 2001

Figure 2

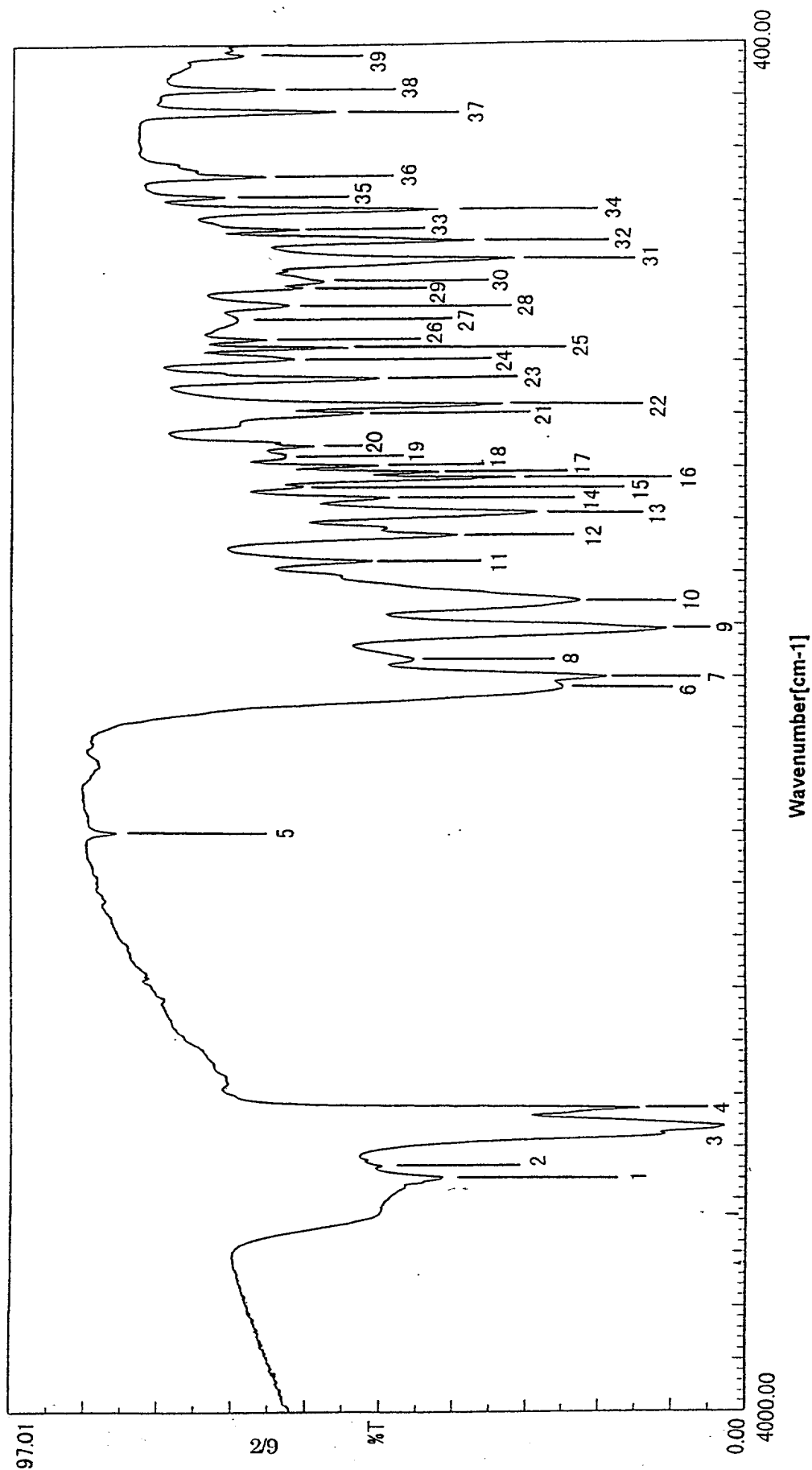


Figure 5

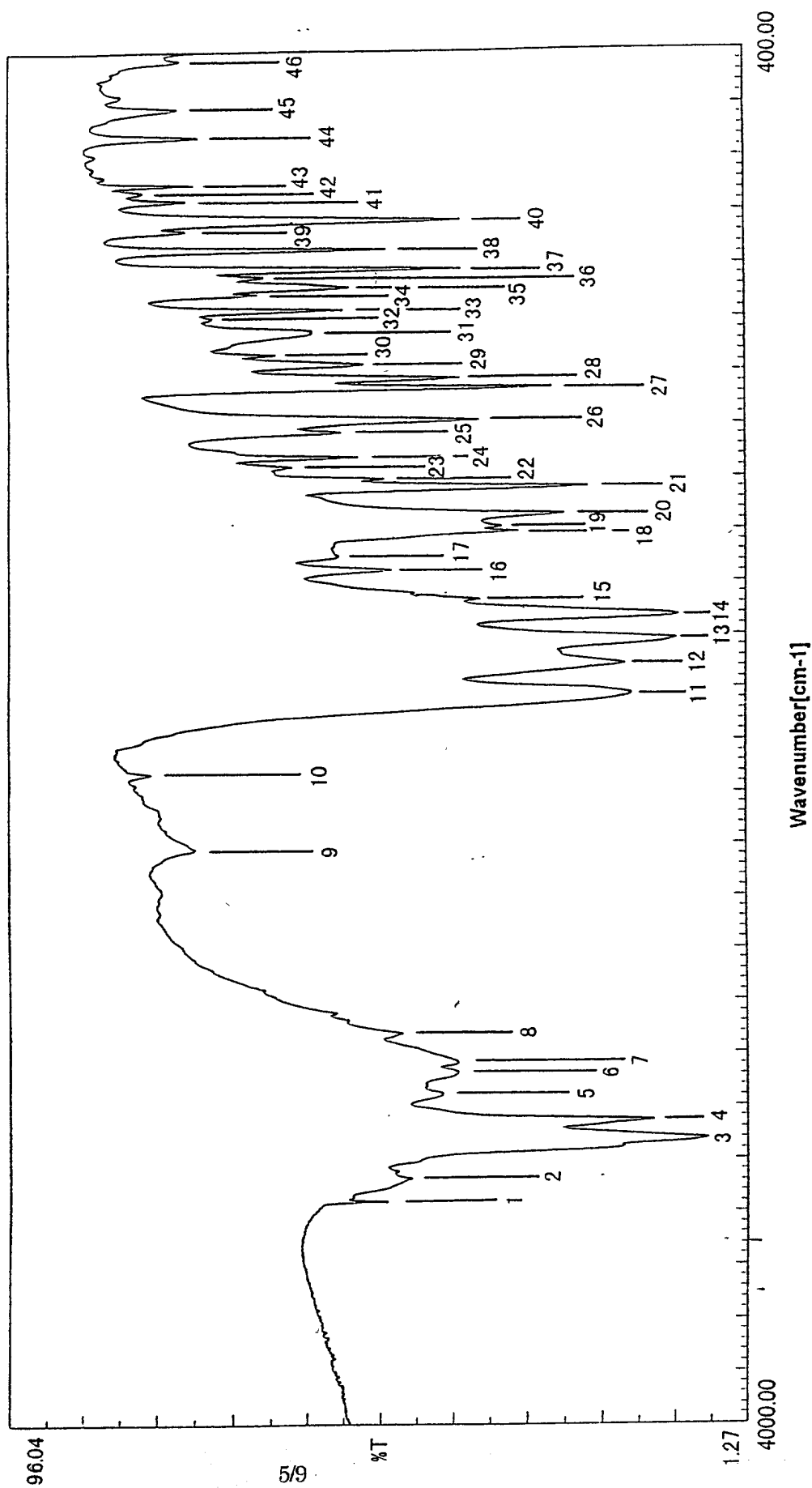
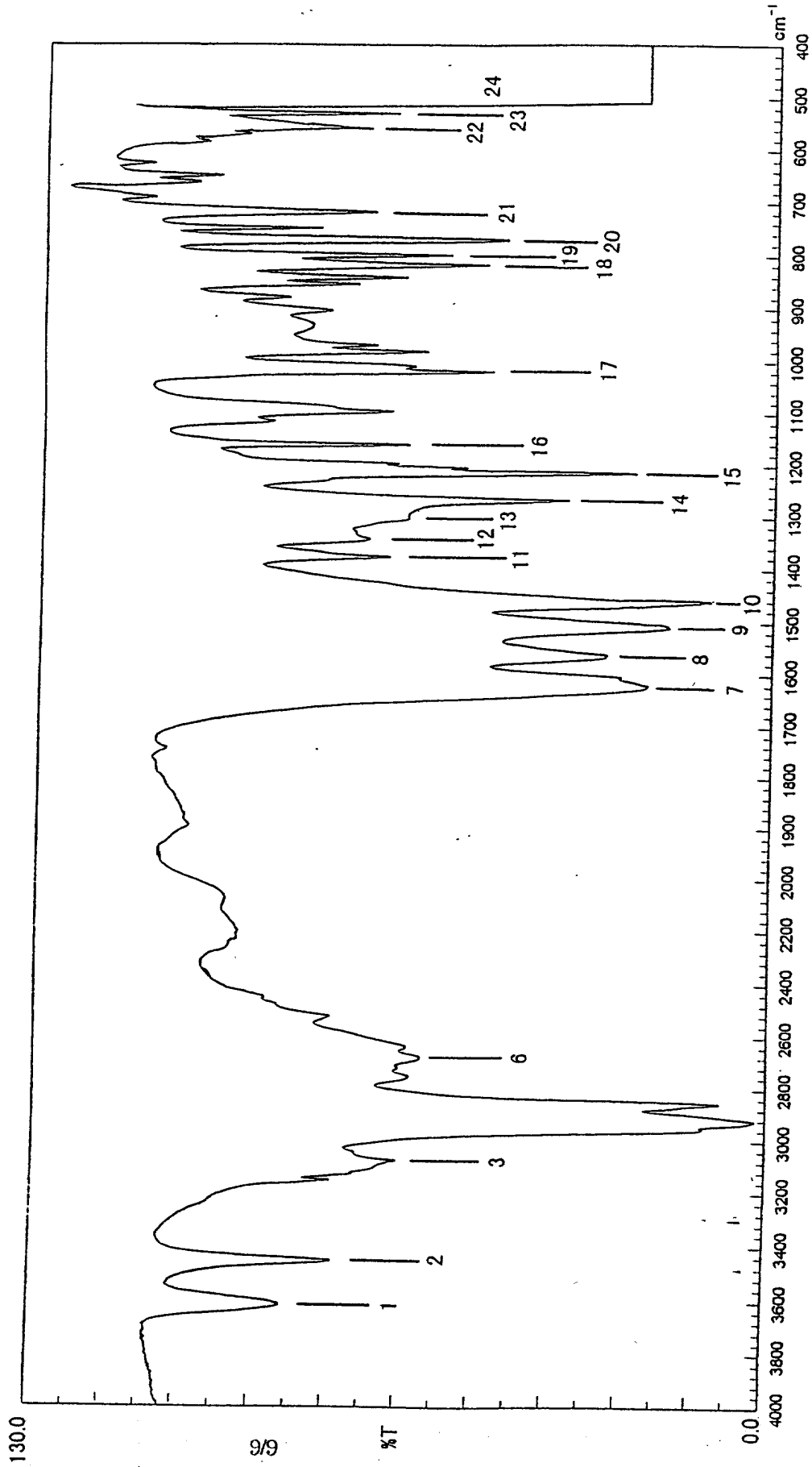


Figure 9



DESCRIPTION

Processes for the preparation of novel substituted propenone derivatives

This application is a 371 of PCT/JP00/03456 filed May 29, 2000.

5 Technical Field

The present invention relates to processes for the preparation of novel substituted propenone derivatives and their crystals, in detail processes for the preparation of their intermediates, 2-acyl-5-benzylfuran derivatives and 1,2,4-triazole-3-carboxylic acid ester derivatives.

10

Background Art

2-Acyl-5-alkylfuran derivatives, which are similar to 2-acyl-5-benzylfuran derivatives, can be prepared by introducing an acyl group to 2-alkylfuran derivatives through Friedel Crafts reaction (Japanese Patent Publication (Kokoku) 1995-78056, Japanese Patent Publication (Kokoku) 1995-78056 and Japanese Patent Publication (Kokai) 1986-53275).

15

2-Alkylfuran derivatives can be prepared by introducing an alkyl group to furan derivatives through Friedel Crafts reaction (Chem. France. 1962, 1166).

20

However, the preparation of 2-acyl-5-benzylfuran derivatives is not disclosed in these documents.

On the other hand, it is known that 1,2,4-triazole-3-carboxylic acid can be prepared by converting an amino group of 3-amino-1,2,4-triazole-5-carboxylic acid to a diazo group, isolating the diazonium salt and reducing.

25

It is known as a reducing method that 1) a diazonium salt is reduced with sodium hypophosphite (NaH_2PO_2) and concentrated hydrochloric acid

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Processes for the preparation of novel substituted propenone derivatives

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Background Art

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15 Publication (Kokoku) 1995-78056, Japanese Patent Publication (Kokoku) 1995-78056 and Japanese Patent Publication (Kokai) 1986-53275).

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It is known as a reducing method that 1) a diazonium salt is reduced with sodium hypophosphite (NaH_2PO_2) and concentrated hydrochloric acid

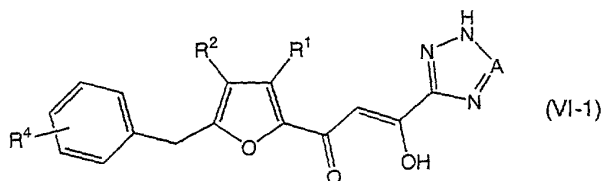
(HCl) under 15 °C (Khim. Geterotsikl. Soedin., 1967, 180-183) and 2) a diazonium salt is reduced at 45 to 50 °C in methanol (Khim. Geterotsikl. Soedin., 1965, 624-626).

In is known as a deaminating method of 3-amino-1,2,4-triazole that
5 diazotation and reduction are carried out at the same time (J. Am. Chem. Soc. 76, 290, 1954).

As another process, 1,2,4-triazole-3-carboxylic acid ester can be prepared by heating acylamidrazone over its melting point (150 to 200 °C) to cyclize (Collect. Czech. Chem. Commun., 49, 1984, 2492-2495, J. Heterocyclic Chem.,
10 25, 651-654, 1998). The document describes that a large scale of cyclization must be preformed under reduced pressure with heating over its melting point for removing the generated water.

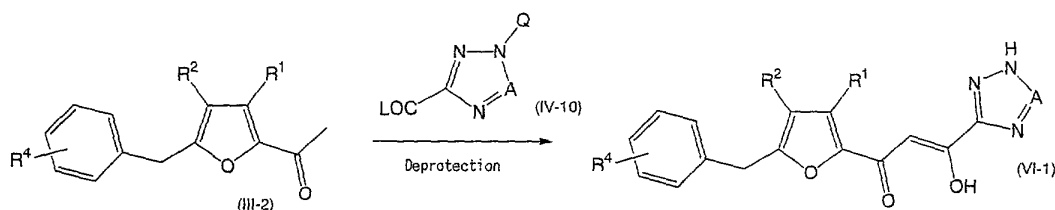
Disclosure of Invention

15 A compound of the formula (VI-1):



wherein R¹, R² and R⁴ each is independently hydrogen, optionally substituted alkyl, optionally substituted alkoxy or halogen; A is CR⁶ or N; and R⁶ is hydrogen, optionally substituted alkyl or optionally substituted aryl, has an
20 anti-HIV activity by inhibiting HIV integrase.

A compound of the formula (VI-1) can be prepared in the following method.



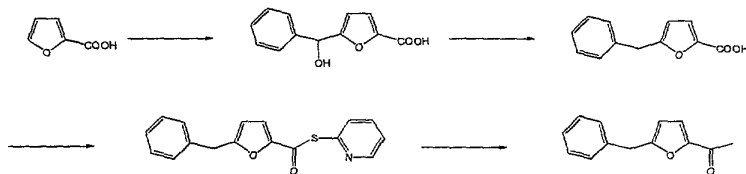
wherein R^1 , R^2 , R^4 and A are as defined above; Q is a protecting group; and L is a leaving group.

Industrial and commercial preparations of 2-acyl-5-benzylfuran derivatives and 1,2,4-triazole-3-carboxylic acid ester derivatives, which are useful intermediates of the compound (VI-1), are desired.

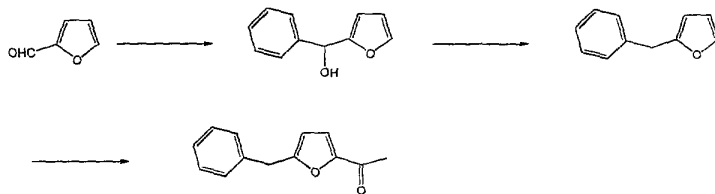
First, the preparation of 2-acyl-5-benzylfuran derivatives is described below.

As a conventional route, for example, the following methods can be thought.

(Method X)



(Method Y)



wherein any ring may be substituted with optionally substituted alkyl, optionally substituted alkoxy and/or halogen.

In method X, 2-furoic acid, a starting material is reacted with benzaldehyde. After removing the hydroxy group from the obtained

compound, the carboxy group is esterified to give 2-pyridine thioester, which is reacted with methyl magnesium bromide to give 2-acetyl-5-benzylfuran. This method requires 2-pyridine thioester which is removed at the following step for converting the carboxy group to acetyl.

5 In method Y, furfural, a starting material, is reacted with phenyl magnesium bromide. After removing the hydroxy group of the obtained compound, 2-acetyl-5-benzylfuran is prepared through Friedel Crafts reaction. The final step of this method requires Friedel Crafts reaction which must be carried out under acidic condition. However, 2-benzylfuran is unstable
10 under acidic condition, so 2-acyl-5-benzylfuran can not be prepared in high yield.

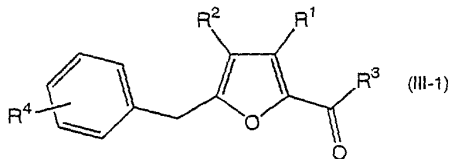
Since both of methods X and Y require many steps and many reagents, 2-acetyl-5-benzylfuran derivatives can not be industrially and commercially prepared.

15 The present inventors have solved the above problems on methods X and Y, and found out industrial and commercial processes for the preparation of 2-acyl-5-benzylfuran derivatives can be achieved through Friedel Crafts reaction of 2-acylfuran derivatives.

20

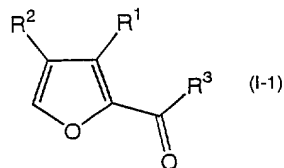
The present inventions of 2-acylfuran derivatives include;

A-1) a process for the preparation of a compound of the formula (III-1):

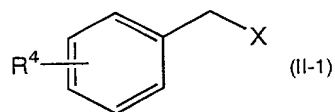


wherein R¹ and R² each is independently hydrogen, optionally substituted
25 alkyl, optionally substituted alkoxy or halogen; R³ is optionally substituted

alkyl or optionally substituted alkoxy; and R⁴ is hydrogen, optionally substituted alkyl, optionally substituted alkoxy or halogen, which comprises reacting a compound of the formula (I-1):



- 5 wherein R¹, R² and R³ each is as defined above, with a compound of the formula (II-1):



wherein R⁴ is as defined above; and X is halogen, in the presence of a Lewis acid,

- 10 A-2) the process according to the above A-1) wherein a reaction solvent is methylene chloride,
A-3) the process according to the above A-1) wherein a reaction solvent is water,
A-4) the process according to any one of the above A-1) to A-3) wherein R³ is
15 methyl,
A-5) the process according to any one of the above A-1) to A-4) wherein R¹ and R² each is hydrogen, and
A-6) the process according to any one of the above A-1) to A-5) wherein R⁴ is 4-fluoro.

20

Second, the preparation of 1,2,4-triazole-3-carboxylic acid ester derivatives is described below.

A conventional process for the preparation of 1,2,4-triazole-3-carboxylic acid comprising a reduction of an isolated diazonium salt is accompanied with

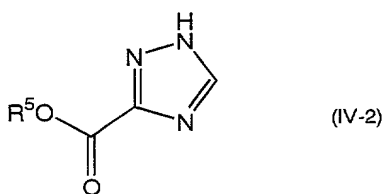
danger of explosion when a large amount of a diazonium salt is treated, so this process is not suitable to industrial production.

A process for the preparation of 1,2,4-triazole-3-carboxylic acid ester comprising a cyclization of acylamidrazone requires heating over a melting
5 point, so this process is not suitable in an industrial scale, too.

Then, the present inventors have solved the above problems and found out processes for the preparation of 1,2,4-triazole-3-carboxylic acid ester derivatives as shown below, which are suitable in an industrial scale.

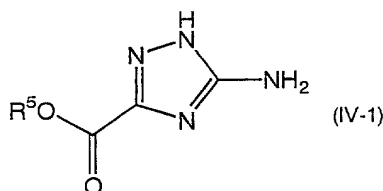
10 The present inventions of 1,2,4-triazole-3-carboxylic acid ester derivatives include;

B-1) a process for the preparation of a compound of the formula (IV-2):



wherein R⁵ is hydrogen or optionally substituted alkyl,

15 which comprises reacting a compound of the formula (IV-1):



wherein R⁵ is as defined above,

with an alkaline metal nitrite or an alkaline-earth metal nitrite in the presence of a reducing agent,

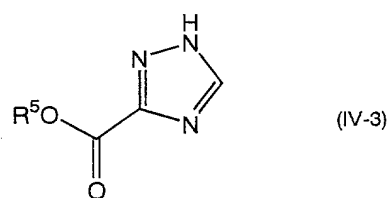
20 B-2) the process according to the above B-1) which comprises reacting a compound of the formula (IV-1) with an alkaline metal nitrite in the presence

of hypophosphorous acid as the reducing agent,

B-3) the process according to the above B-1) or B-2) which is carried out under the addition of a small amount of alcohol,

B-4) the process according to any one of the above B-1) to B-3) wherein R⁵ is
5 hydrogen,

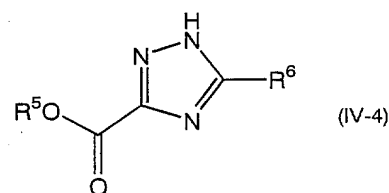
B-5) a process for the preparation of a compound of the formula (IV-3):



wherein R⁵ is optionally substituted alkyl,

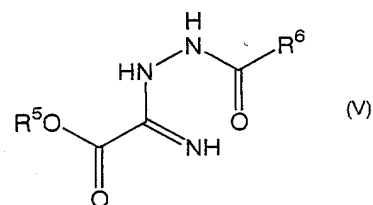
which comprises preparing 1,2,4-triazole-3-carboxylic acid through the
10 process according to the above B-4) and esterifying the obtained compound,

B-6) a process for a compound of the formula (IV-4):



wherein R⁵ is hydrogen or optionally substituted alkyl; and R⁶ is hydrogen,
optionally substituted alkyl or optionally substituted aryl,

15 which comprises cyclizing a compound of the formula (V):



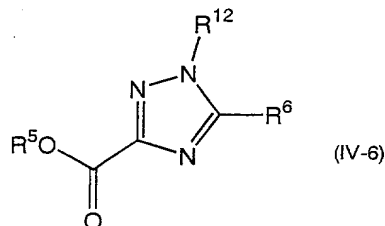
wherein R⁵ and R⁶ are as defined above,

in the presence of trialkylorthoester or a catalytic amount of an acid,

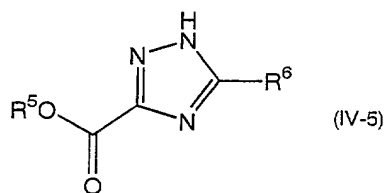
B-7) the process according to the above B-6) wherein R^5 is optionally substituted alkyl,

B-8) the process according to the above B-6) wherein R^5 is optionally substituted alkyl; and R^6 is hydrogen,

5 B-9) a process for the preparation of a compound of the formula (IV-6):

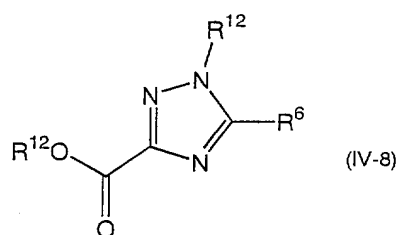


wherein R^5 is optionally substituted alkyl; R^6 is hydrogen, optionally substituted alkyl or optionally substituted aryl; and R^{12} is a group of the formula: $-R^7$ wherein R^7 is trityl, optionally substituted sulfamoyl or
10 optionally substituted alkoxymethyl, a group of the formula: $-C(OR^8)R^9-CHR^{10}R^{11}$ wherein R^8 is optionally substituted alkyl; R^9 , R^{10} and R^{11} each is independently hydrogen or optionally substituted alkyl; or R^8 and R^{10} may be taken together to form optionally substituted alkylene, or hydroxymethyl, which comprises preparing a compound of the formula (IV-5):

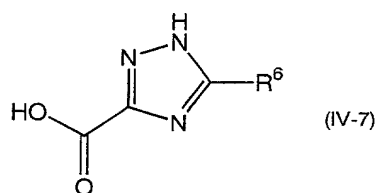


15 wherein R^5 and R^6 are as defined above, through the process according to any one of the above B-1) to B-3) and B-5) to B-8), and reacting the obtained compound with a compound of the formula: R^7X wherein R^7 is as defined above; and X is halogen, a compound of the formula: $(R^8O)R^9C=CR^{10}R^{11}$
20 wherein R^8 , R^9 , R^{10} and R^{11} are as defined above, or formaldehyde,

B-10) a process of the preparation of a compound of the formula (IV-8):



wherein R^6 is hydrogen, optionally substituted alkyl or optionally substituted aryl; and R^{12} is a group of the formula: $-R^7$ wherein R^7 is trityl, optionally substituted sulfamoyl or optionally substituted alkoxymethyl, a group of the formula: $-C(OR^8)R^9-CHR^{10}R^{11}$ wherein R^8 is optionally substituted alkyl; R^9 , R^{10} and R^{11} each is independently hydrogen or optionally substituted alkyl, or R^8 and R^{10} may be taken together to form optionally substituted alkylene, or hydroxymethyl, which comprises preparing a compound of the formula (IV-7):



wherein R^6 is as defined above, through the process according to the above B-4) or B-6), and reacting the obtained compound with a compound of the formula: R^7X wherein R^7 is as defined above; and X is halogen, a compound of the formula: $(R^8O)R^9C=CR^{10}R^{11}$ wherein R^8 , R^9 , R^{10} and R^{11} are as defined above, or formaldehyde,

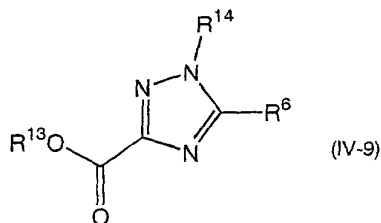
B-11) the process according to the above B-9) or B-10) which comprises reacting a compound of the formula (IV-7) with a compound of the formula: R^7X wherein R^7 is trityl,

B-12) the process according to the above B-9) or B-10) which comprises reacting a compound of the formula (IV-7) with a compound of the formula:

$(R^8O)R^9C=CR^{10}R^{11}$ wherein R^8 and R^{10} are taken together to form trimethylene; and R^9 and R^{11} each is hydrogen,

B-13) the process according to the above B-9) or B-10) which comprises reacting a compound of the formula (IV-7) with a compound of the formula: $(R^8O)R^9C=CR^{10}R^{11}$ wherein R^8 and R^9 each is methyl; and R^{10} and R^{11} each is hydrogen,

5 B-14) a compound of the formula (IV-9):



wherein R^6 is hydrogen or alkyl; R^{13} is alkyl, a group of the formula: $-R^7$ wherein R^7 is trityl, optionally substituted sulfamoyl or alkoxymethyl, a group of the formula: $-C(OR^8)R^9-CHR^{10}R^{11}$ wherein R^8 is alkyl; R^9 , R^{10} and R^{11} each is independently hydrogen or alkyl; or R^8 and R^{10} may be taken together to form alkylene, or hydroxymethyl; and R^{14} is a group of the formula: $-R^7$ wherein R^7 is as defined above, a group of the formula: $-C(OR^8)R^9-CHR^{10}R^{11}$ wherein R^8 , R^9 , R^{10} and R^{11} are defined above, or hydroxymethyl,

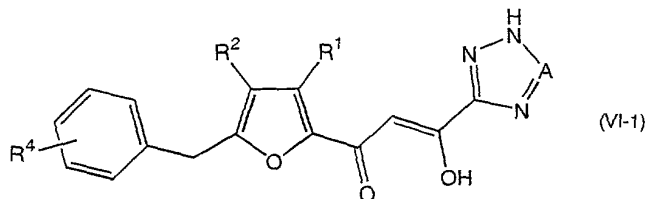
provided that a compound wherein R^6 is hydrogen; R^{13} is methyl; and R^{14} is trityl, a compound wherein R^6 is hydrogen; R^{13} is methyl; and R^{14} is tetrahydropyran-2-yl, and a compound wherein R^6 is hydrogen; R^{13} is ethyl; and R^{14} is trityl are excluded,

B-15) the compound according to the above B-14) wherein R^6 is hydrogen; R^{13} is methyl or ethyl; and R^{14} is tetrahydropyran-2-yl, hydroxymethyl, methoxymethyl, ethoxymethyl, N,N-dimethylsulfamoyl, (1-methoxy-1-methyl)ethyl, (1-ethoxy)ethyl, (1-ethoxy-1-methyl)ethyl, (1-n-propoxy)ethyl, (1-n-butoxy)ethyl or (1-isobutoxy)ethyl.

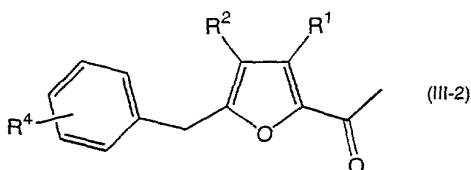
The present inventions for the preparation of substituted propenone

derivatives accompanied by the above A) and/or B) include;

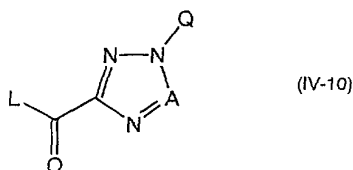
C-1) a process for the preparation of a compound of the formula (VI-1):



wherein R¹, R² and R⁴ each is independently hydrogen, optionally substituted
5 alkyl, optionally substituted alkoxy or halogen; A is CR⁶ or NA; and R⁶ is
hydrogen, optionally substituted alkyl or optionally substituted aryl, which
comprises preparing a compound of the formula (III-2):



wherein R¹, R² and R⁴ are as defined above, through the process according to
10 the above A-4), reacting the compound of the formula (III-2) with a compound
of the formula (IV-10):



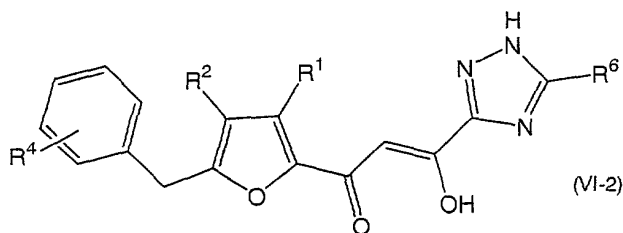
wherein A is as defined above, Q is a protecting group; and L is a leaving
group, in the presence of a base, and deprotecting Q,

15 C-2) the process according to the above C-1) wherein R¹ and R² each is
hydrogen; and R⁴ is halogen,

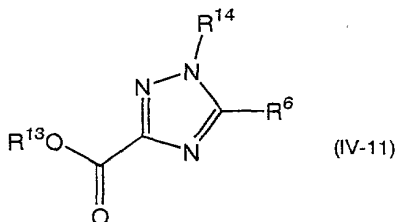
C-3) the process according to the above C-1) or C-2) wherein R⁴ is 4-fluoro,

C-4) the process according to any one of the above C-1) to C-3) wherein A is
CH,

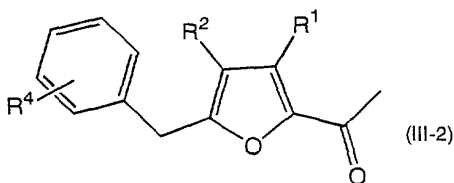
20 C-5) a process for the preparation of a compound of the formula (IV-2):



wherein R¹, R² and R⁴ each is independently hydrogen, optionally substituted alkyl, optionally substituted alkoxy or halogen; and R⁶ is hydrogen, optionally substituted alkyl or optionally substituted aryl, which comprises preparing a
 5 compound of the formula (IV-11):



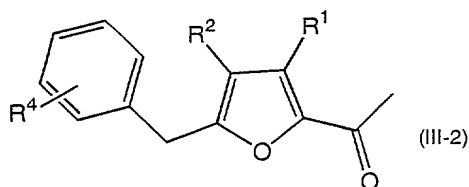
wherein R⁶ is as defined above, R¹³ is optionally substituted alkyl, a group of the formula: -R⁷ wherein R⁷ is trityl, optionally substituted sulfamoyl or optionally substituted alkoxymethyl, a group of the formula: -C(OR⁸)R⁹.
 10 CHR¹⁰R¹¹ wherein R⁸ is alkyl; R⁹, R¹⁰ and R¹¹ each is independently hydrogen or optionally substituted alkyl; or R⁸ and R¹⁰ may be taken together to form alkylene, or hydroxymethyl; and R¹⁴ is a group of the formula: -R⁷ wherein R⁷ is as defined above, a group of the formula: -C(OR⁸)R⁹.CHR¹⁰R¹¹ wherein R⁸, R⁹, R¹⁰ and R¹¹ are defined above, or hydroxymethyl, through the process
 15 according to the above B-9) or B-10), reacting the obtained compound with a compound of the formula(III-2):



wherein R¹, R² and R⁴ are as defined above, and deprotecting R¹⁴,

C-6) the process according to the above C-5) which comprises preparing the

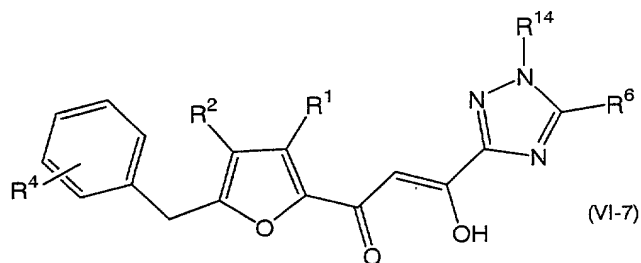
compound of the formula (III-2):



wherein R¹, R² and R⁴ each is independently hydrogen, optionally substituted alkyl, optionally substituted alkoxy or halogen through the process according to the above A-4),

C-7) the process according to the above C-5) or C-6) wherein R¹, R² and R⁶ each is hydrogen; and R⁴ is halogen,

C-8) a compound of the formula (VI-7):



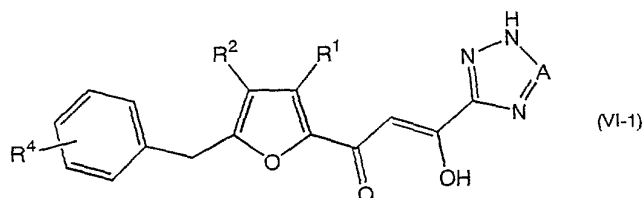
wherein R¹, R² and R⁴ each is independently hydrogen, optionally substituted alkyl, optionally substituted alkoxy or halogen; R⁶ is hydrogen, optionally substituted alkyl or optionally substituted aryl; and R¹⁴ is a group of the formula: -R⁷ wherein R⁷ is trityl, optionally substituted sulfamoyl or optionally substituted alkoxymethyl, a group of the formula: -C(OR⁸)R⁹. CHR¹⁰R¹¹ wherein R⁸ is alkyl; R⁹, R¹⁰ and R¹¹ each is independently hydrogen or optionally substituted alkyl; or R⁸ and R¹⁰ may be taken together to form alkylene, or hydroxymethyl, and

C-9) the compound according to the above C-8) wherein R⁴ is 4-fluoro; R¹, R² and R⁶ each is hydrogen; and R¹⁴ is trityl, tetrahydropyran-2-yl, hydroxymethyl, methoxymethyl, ethoxymethyl, N,N-dimethylsulfamoyl, (1-methoxy-1-methyl)ethyl, (1-ethoxy)ethyl, (1-ethoxy-1-methyl)ethyl, (1-n-

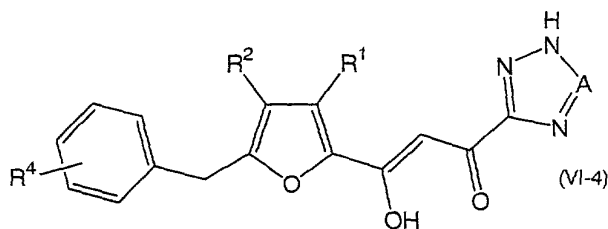
propoxy)ethyl, (1-n-butoxy)ethyl or (1-isobutoxy)ethyl.

The present inventions for a crystal of the above novel substituted propenone derivative include;

- 5 D-1) a crystal of an isomer having a chemical structure of the formula (VI-1):



- wherein A is CR⁶ or N; R⁶ is hydrogen, optionally substituted alkyl or optionally substituted aryl; and R¹, R² and R⁴ each is independently hydrogen, optionally substituted alkyl, optionally substituted alkoxy or halogen,
- 10 D-2) the crystal according to the above D-1) wherein R¹ and R² each is hydrogen; R⁴ is p-fluoro; and A is CH,
- D-3) the crystal according to the above D-2) of which crystal parameters by single crystal X-ray diffraction are unit cell constants $a = 32.432(2) \text{ \AA}$, $b =$
- 15 $10.886(2) \text{ \AA}$, $c = 7.960(2) \text{ \AA}$, $\alpha = 90.00^\circ$, $\beta = 90.00^\circ$, $\gamma = 90.00^\circ$, $V = 2810(1) \text{ \AA}^3$, $Z = 8$; a space group Pbc_a; and density of 1.481 g/cm^3 ,
- D-4) the crystal according to the above D-2) of which diffraction angles (2θ) of main peaks by powder X-ray diffraction are 20.380, 21.280, 21.340, 23.140, 23.360, 23.540, 25.860, 27.460, 27.500, 28.100, 28.180, 29.400 and 29.480
- 20 (degree),
- D-5) a crystal of an isomer having a chemical structure of the formula(VI-4):



wherein A is CR⁶ or N; R⁶ is hydrogen, optionally substituted alkyl or optionally substituted aryl; and R¹, R² and R⁴ each is independently hydrogen, optionally substituted alkyl, optionally substituted alkoxy or halogen,

5 D-6) the crystal according to the above D-5) wherein R¹ and R² each is hydrogen; R⁴ is p-fluoro; and A is CH,

D-7) the crystal according to the above D-6) of which crystal parameters by single crystal X-ray diffraction are unit cell constants $a = 11.9003(7) \text{ \AA}$, $b = 9.7183(5) \text{ \AA}$, $c = 13.2617(8) \text{ \AA}$, $\alpha = 90.00^\circ$, $\beta = 109.450(4)^\circ$, $\gamma = 90.00^\circ$, $V =$
 10 $1446.2(1) \text{ \AA}^3$ and $Z = 4$; a space group $P2_1/n$; and density of 1.439 g/cm^3 ,

D-8) the crystal according to the above D-6) of which diffraction angles (2θ) of main peaks by powder X-ray diffraction are 8.760, 19.600, 22.080, 23.760, 26.200, 27.580 and 29.080 (degree), and

D-9) a crystal of an isomer of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-
 15 (1*H*-1,2,4-triazole-3-yl)propenone of which diffraction angles (2θ) of main peaks by powder X-ray diffraction are 10.520, 13.860, 15.680, 18.160, 22.840, 26.180 and 28.120 (degree).

Each term to be used in the present specification is explained below.

20 The term "alkyl" includes C1 to C6 straight or branched alkyl, for example, methyl, ethyl, n-propyl, isopropyl, n-butyl, isobutyl, sec-butyl, tert-butyl, n-pentyl, isopentyl, neopentyl, tert-pentyl, n-hexyl, isohexyl or the like. Preferred is methyl or ethyl.

The term "alkylene" includes C2 to C6 straight or branched alkylene,

for example, ethylene, propylene, trimethylene, ethylethylene, tetramethylene or the like. Preferred is trimethylene.

The term "alkoxy" includes C1 to C6 straight or branched alkoxy, for example, methoxy, ethoxy, n-propoxy, isopropoxy, n-butoxy, isobutoxy, sec-
5 butoxy, tert-butoxy, n-pentyloxy, isopentyloxy, neopentyloxy, tert-pentyloxy, n-hexyloxy, isohexyloxy or the like. Preferred is methoxy or ethoxy.

The term "alkoxymethyl" includes methyl group substituted with the above alkyloxy, for example, methoxymethyl, ethoxymethyl, n-propoxymethyl, isopropoxymethyl, n-butoxymethyl, isobutoxymethyl, sec-butoxymethyl, tert-
10 butoxymethyl, n-pentyloxymethyl, isopentyloxymethyl, neopentyloxymethyl, tert-pentyloxymethyl, n-hexyloxymethyl, isohexyloxymethyl or the like. Preferred is methoxy or ethoxymethyl.

The term "aryl" includes C6 to C14 aromatic carbocycle, for example, phenyl, naphthyl, anthryl, phenanthryl or the like. Preferred is phenyl.

15 The term "halogen" includes fluoro, chloro, bromo or iodo. Preferred in X is chloro or bromo. Preferred in R¹³ is fluoro, especially para-substituted fluoro.

The term "trityl" means a group of the formula: -CPh₃ wherein Ph is phenyl.

20 The term "optionally substituted sulfamoyl" includes unsubstituted sulfamoyl and sulfamoyl mono- or di-substituted with alkyl, for example, sulfamoyl, N-methylsulfamoyl, N,N-dimethylsulfamoyl, N-ethylsulfamoyl, N,N-diethylsulfamoyl or the like.

The substituents of "optionally substituted alkyl", "optionally
25 substituted alkoxyethyl" and "optionally substituted alkylene" include aryl (e.g., phenyl or the like), cycloalkyl (e.g., cyclopropyl, cyclopentyl, cyclohexyl or the like), cyano, nitro, hydroxy, amino, halogenated alkyl (e.g.,

trifluoromethyl or the like) or the like.

The substituents of "optionally substituted aryl" include alkyl (e.g., methyl, ethyl or the like), alkenyl (e.g., vinyl, allyl or the like), halogen, hydroxy, alkoxy (e.g., methoxy, ethoxy or the like), halogenated alkyl (e.g., trifluoromethyl or the like), nitro, sulfamoyl, amino, alkyl-substituted amino (e.g., methylamino, dimethylamino or the like), carboxy, alkoxycarbonyl (e.g., methoxycarbonyl or the like), cyano or the like.

Brief Description of Drawings

10 Figure 1 shows a powder X-ray diffraction chart of a crystal (type I) of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propenone.

15 Figure 2 shows an infrared absorption spectrum chart of a crystal (type I) of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propenone.

Figure 3 shows a differential scanning calorimetry chart of a crystal (type I) of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propenone.

20 Figure 4 shows a powder X-ray diffraction chart of a crystal (type II) of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propenone.

Figure 5 shows an infrared absorption spectrum chart of a crystal (type II) of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propenone.

25 Figure 6 shows a differential scanning calorimetry chart of a crystal (type II) of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propenone.

Figure 7 shows a powder X-ray diffraction chart of a crystal (type III) of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propanone.

Figure 8 shows an infrared absorption spectrum chart of a crystal (type III) of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propanone.

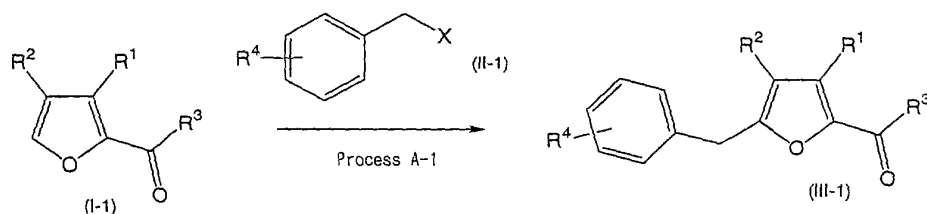
Figure 9 shows a differential scanning calorimetry chart of a crystal (type III) of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propanone.

Best Mode for Carrying out the Invention

The present inventions are explained with the following process A, process B and process C.

First, a process for the preparation of 2-acyl-5-benzylfuran derivatives is explained below.

Process A1



wherein R^1 , R^2 and R^4 each is independently hydrogen, optionally substituted alkyl, optionally substituted alkoxy or halogen; R^3 is optionally substituted alkyl or optionally substituted alkoxy.

This scheme shows a process for the preparation of 2-acyl-5-benzylfuran derivatives (III-1) which comprises reacting 2-acylfuran derivatives (I-1) with benzylhalide derivatives (II-1) in the presence of a

Lewis acid through Friedel Crafts reaction.

The compound (I-1) includes 2-acetylfuran, 2-acetyl-3-methylfuran, 2-acetyl-4-methylfuran, 2-acetyl-3,4-dimethylfuran, 2-acetyl-3-methoxyfuran, 2-acetyl-4-methoxyfuran, 2-acetyl-3,4-dimethoxyfuran, 2-acetyl-3-chlorofuran, 2-acetyl-4-chlorofuran, 2-acetyl-3,4-dichlorofuran, 2-propionylfuran, 3-methyl-2-propionylfuran, 4-methyl-2-propionylfuran, 3,4-dimethyl-2-propionylfuran, 3-methoxy-2-propionylfuran, 4-methoxy-2-propionylfuran, 3,4-dimethoxy-2-propionylfuran, 3-chloro-2-propionylfuran, 4-chloro-2-propionylfuran, 3,4-dichloro-2-propionylfuran, methyl 2-furoic acetate, ethyl 2-furoic acetate or the like. Preferred is 2-acetylfuran.

The compound (II-1) includes benzylchloride, benzylbromide, 4-methylbenzylchloride, 4-methylbenzylbromide, 4-methoxybenzylchloride, 4-methoxybenzylbromide, 4-fluorobenzylchloride, 4-fluorobenzylbromide, 4-chlorobenzylchloride, 4-chlorobenzylbromide, 3-methylbenzylchloride, 3-methylbenzylbromide, 3-methoxybenzylchloride, 3-methoxybenzylbromide, 3-fluorobenzylchloride, 3-fluorobenzylbromide, 3-chlorobenzylchloride, 3-chlorobenzylbromide or the like. Preferred is 4-fluorobenzylchloride or 4-fluorobenzylbromide.

A Lewis acid includes zinc chloride (ZnCl_2), stannic chloride (SnCl_4), ferric chloride (III) (FeCl_3), aluminum chloride (AlCl_3), BF_3 /ether or the like. Preferred is zinc chloride or stannic chloride.

This process can be performed without a reaction solvent. When a reaction solvent is used, water, carbon disulfide, methylene chloride, dichloroethane, chloroform or the like can be used. Preferred is water or methylene chloride.

When methylene chloride is used as a reaction solvent, the produced compound (III-1) forms a complex with a Lewis acid, a crystal of which is

precipitated in the reaction solvent. The crystal is filtered off, dissolved in water, extracted with an organic solvent to give the compound (III-1) in high quality.

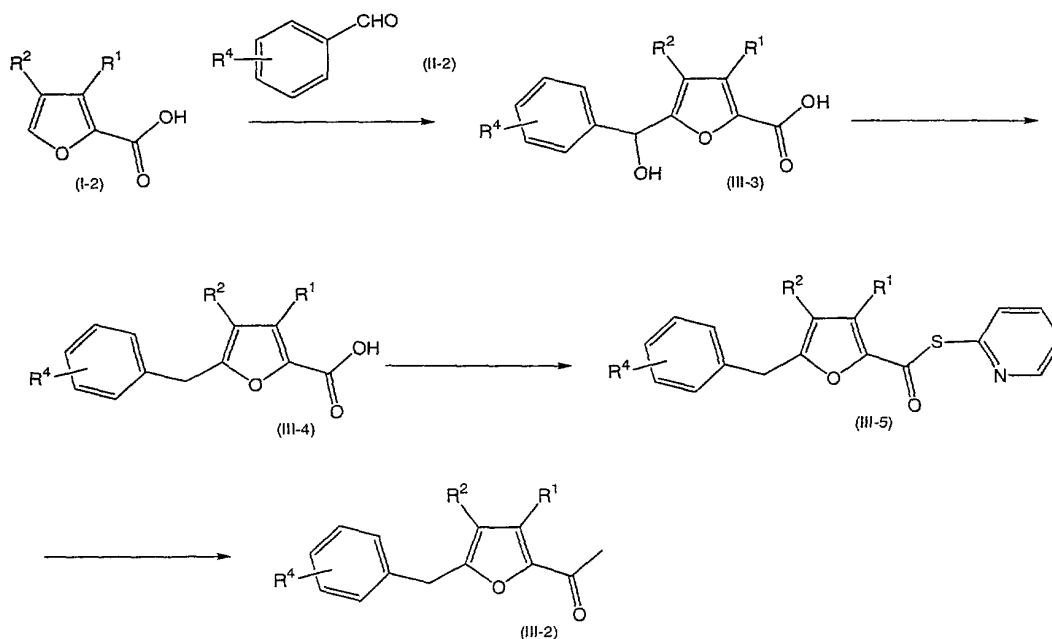
When water is used as a reaction solvent, the reaction can be performed mildly, which is economically and environmentally preferable.

The reaction temperature is -50 to 150 °C, preferably, 0 to 100 °C.

The reaction time is 1 to 48 hours, preferably 1 to 24 hours.

2-Acyl-5-benzylfuran derivatives such as a compound (III-1) or (III-2) can be prepared through the following processes such as Process A-2 and A-3 besides the above Process A1.

Process A2



wherein R¹, R² and R⁴ each is independently hydrogen, optionally substituted alkyl, optionally substituted alkoxy or halogen.

The above process includes the following four steps. First, a coupling reaction of a compound (I-2) and (II-2) produces a compound (III-3). Second,

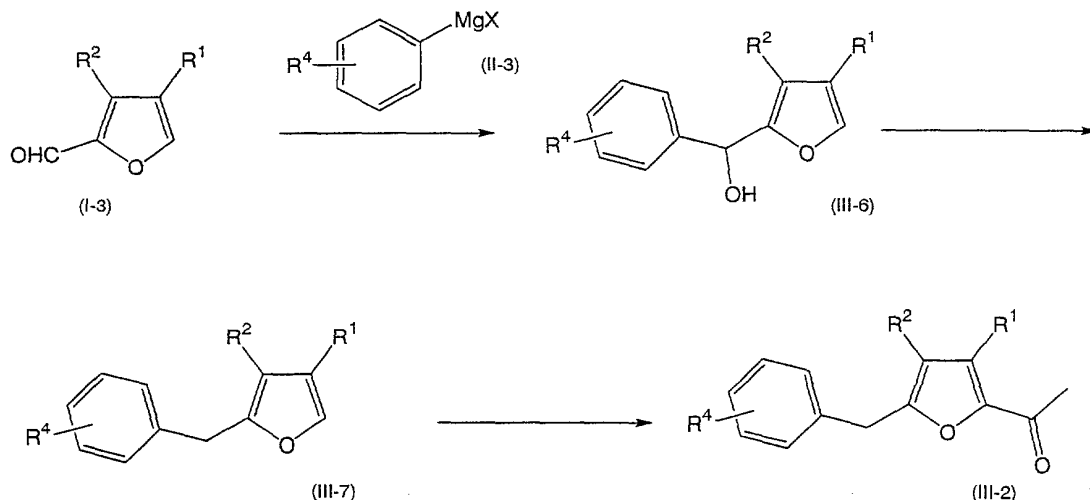
a dehydroxy reaction of the compound (III-3) produces a compound (III-4).
 Third, an introduction of a leaving group to a carboxy group of the compound
 (III-4) produces a compound (III-5). Finally, a reaction of the compound
 (III-5) with methyl magnesium halide (e.g., methyl magnesium bromide)
 5 produces a compound (III-2).

The above coupling reaction can be performed in the presence of a base
 (e.g., LDA) under cooling.

The dehydroxy reaction can be preformed by reduction with trimethyl
 chlorosilane and sodium iodide. This reaction can be performed by a
 10 hydrogenation in the presence of palladium carbon after an acetylation with
 acetic anhydride in the presence of triethylamine.

The converting of a carboxy group to an acetyl group can be performed
 by the following steps. First, a compound (III-4) is reacted with
 thionylhalide (e.g., thionylchloride) in the presence of a catalytic amount of
 15 dimethylformamide or the like. Second, the obtained compound is reacted
 with methyl magnesium halide (e.g., methyl magnesium chloride) in the
 presence of a catalytic amount of ironic acetyl acetate.

Process A3

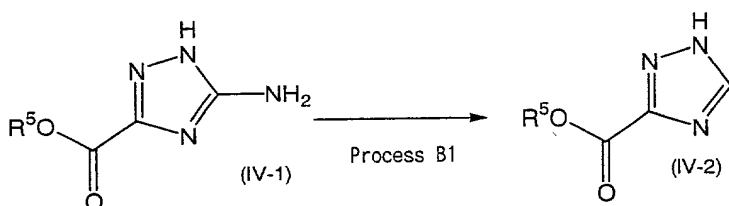


wherein R¹, R² and R⁴ each is independently hydrogen, optionally substituted alkyl, optionally substituted alkoxy or halogen; and X is halogen.

The above process for the preparation of a compound (III-2) comprises reacting a compound (I-3), a starting material, with a compound (II-3),
5 removing a hydroxy group, and Friedel-Crafts reaction.

Second, the process for the preparation of 1,2,4-triazole-3-carboxylic acid ester derivatives is explained below.

Process B1



wherein R⁵ is hydrogen or optionally substituted alkyl.

This scheme shows a process for the preparation of a compound (IV-2) which includes a deamination of a compound (IV-1), in detail, a directly deamination without isolating a diazonium salt.

15 An alkali metal nitrite to be used includes sodium nitrite, potassium nitrite, lithium nitrite or the like. Preferred is sodium nitrite.

An alkaline-earth metal nitrite can be used in place of alkali metal nitrite. An alkaline-earth metal nitrite includes calcium nitrite or the like.

A reducing agent includes hypophosphorous acid (H₃PO₂),
20 phosphorous acid (H₃PO₃), Ca(H₂PO₂)₂, NaBH(OAc)₃, PhSH, H₂CO or the like. Preferred is hypophosphorous acid (H₃PO₂).

To a compound (IV-1) is added an aqueous solution of a reducing agent (e.g., hypophosphorous acid) and warmed at 30 to 60 °C (preferably, 40 to 50 °C). To the suspension is added dropwise under stirring at 30 to 60 °C

(preferably, under 50 °C) for approximately 10 to 60 minutes (preferably approximately 30 minutes) an aqueous solution of an alkali metal nitrite or an alkaline-earth metal nitrite. After addition, the reaction mixture is stirred at the same temperature for 10 to 60 minutes (preferably 30 minutes), cooled to 0 - 20 °C (preferably, approximately 5 °C) and stirred for 10 to 60 minutes (preferably, approximately 30 minutes). The objective, a compound (IV-2) can be prepared by filtering the obtained suspension.

This process may be performed in the presence of a diluted hydrochloric acid (e.g., 6 % hydrochloric acid) or the like.

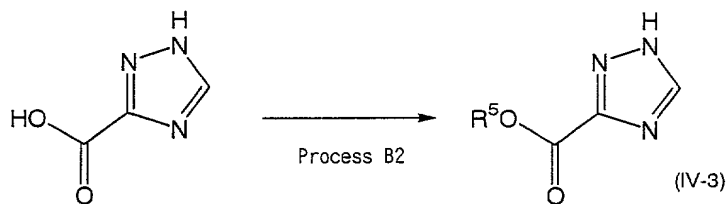
Preferred in this process is an addition of a small amount (1-10 (v/v) %, preferably, 2-3 (v/v) % to all volume of a solvent to be used, or approximately 0.2 mole equivalent to a compound (I)) of alcohol. A gas is produced for approximately 10 minutes by adding an aqueous solution of an alkali metal nitrite. An addition of alcohol suppresses a vigorous production of the gas as well as controlling the adding rate of an aqueous solution of an alkali metal nitrite.

An alcohol includes an alkyl alcohol, for example, isopropylalcohol, isobutanol, methanol, ethanol, n-propylalcohol, n-butanol or the like. Preferred is isopropylalcohol or isobutanol.

A compound (IV-1) includes 3-amino-1,2,4-triazole-5-carboxylic acid and its alkyl ester derivatives (e.g., 3-amino-1,2,4-triazole-5-carboxylic acid methyl ester, 3-amino-1,2,4-triazole-5-carboxylic acid ethyl ester). Preferred is a compound wherein R⁵ is hydrogen, 3-amino-1,2,4-triazole-5-carboxylic acid.

When a compound (IV-1) is an alkyl ester derivative of 3-amino-1,2,4-triazole-5-carboxylic acid, the reaction temperature should be controlled for preventing its ester part from converting to carboxylic acid.

Process B2



1,2,4-triazole-3-carboxylic acid

wherein R⁵ is optionally substituted alkyl.

5 This scheme shows a process for the preparation of a compound (IV-3) which comprises esterifying 1,2,4-triazole-3-carboxylic acid prepared through the process B1 wherein R¹ is hydrogen.

A carboxylic acid can be esterified in accordance with the usual manner of reacting it with alcohol in the presence of an acid catalyst.

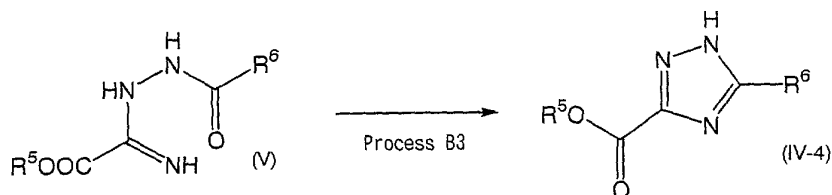
10 To a solution of 1,2,4-triazole-3-carboxylic acid in alcohol (e.g., methanol, ethanol, n-propanol, n-butanol, benzylalcohol) is added dropwise under cooling with stirring, thionylhalide (e.g., thionylchloride, thionylbromide). The mixture is stirred at 60 to 90 °C (preferably, approximately 70 °C) for 1 to 10 hours (preferably, approximately 4 hours).

15 The solvent is removed under reduced pressure, and the residue was filtered off and washed with an appropriate organic solvent (e.g., ether, ethylacetate, n-hexane) to give the objective, a compound (IV-3).

A condensing agent such as DCC, EDC or the like can be used in a coupling reaction of carboxylic acid and alcohol.

20 Another method of an esterifying reaction includes a method reacting with halogenated alkyl (e.g., methyl iodide, ethylbromide) in the presence of a base, a method reacting with diazomethane or trimethylsilyl diazomethane, a method reacting with alkene (e.g., isobutylene) or the like.

Process B3



wherein R⁵ is hydrogen or optionally substituted alkyl, R⁶ is hydrogen, optionally substituted alkyl or optionally substituted aryl.

5 This scheme shows a process for the preparation of a compound (IV-4) which comprises a cyclization of a compound (V). In the past, this process should be performed at a high temperature (over melting point of a compound (V). This process can be performed by using the present invention at lower temperature, suitable to industrial production.

10 This process includes two kinds of methods, as shown below.

1) A method performed in the presence of trialkylorthoester.

To a compound (V) are added trialkylorthoester (e.g., triethyl orthoformate, trimethyl orthoformate, triethyl orthoacetic acid, trimethyl orthoacetic acid, triethyl orthobenzoic acid, trimethyl orthobenzoic acid, 15 triethyl orthopropionic acid, trimethyl orthopropionic acid) and an organic solvent (e.g., benzene, toluene, xylene). The mixture is stirred at 100 to 130 °C (preferably, 110 to 120 °C) for 1 to 10 hours (preferably, approximately 2.5 hours). A by-product, alcohol (produced from trialkylortho ester) is removed under a usual pressure. The distilled product is cooled at 0 to 20 °C 20 (preferably, under 10 °C) and allowed to stand for 0.5 to 10 hours (preferably, approximately 1 hour). The objective, a compound (IV-4) can be obtained by filtering the precipitated crystal.

2) A method performed in the presence of an acid catalyst.

To a compound (V) are added a catalytic amount (0.01-0.5, preferably,

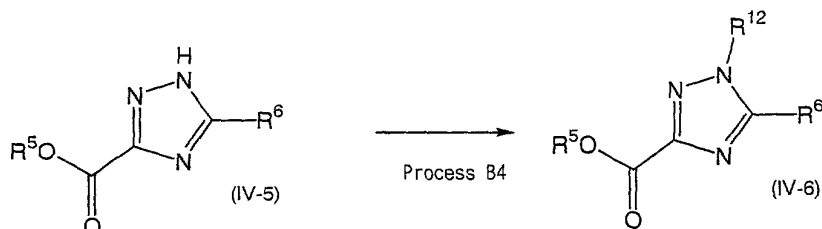
approximately 0.1 mole equivalent to a compound (V)) of an acid (e.g., methane sulfonic acid, benzene sulfonic acid, p-toluenesulfonic acid, p-toluenesulfonic acid mono hydrate, hydrochloric acid, sulfuric acid, nitric acid, polyphosphoric acid) and an organic solvent (e.g., dimethylformamide, N-methylpyrrolidone). The mixture is stirred at 100 to 130 °C (preferably, 110 to 120 °C) for 1 to 10 hours (preferably, approximately 3 hours). The reaction mixture is cooled at 0 to 20 °C (preferably, under 10 °C), mixed with an organic solvent (e.g., benzene, toluene, xylene) and stirred under cooling for 0.5 to 10 hours (preferably, approximately 1.5 hours). The objective, a compound (IV-4) can be obtained by a filtration of the precipitated crystal.

A compound (V) can be prepared by reacting thioformimide with acylhydrazine (Collect. Czech. Chem. Commun., 49, 1984, 2492-2495, J. Heterocyclic Chem., 25, 651-654, 1998) as well as by reacting formimide with acyl hydrazine.

A compound (V) includes ethyl β formyl oxalylamidrazone (a compound wherein R^5 is ethyl; and R^6 is hydrogen), methyl β formyl oxalylamidrazone (a compound wherein R^5 is methyl; and R^6 is hydrogen), ethyl β acetyloxalylamidrazone (a compound wherein R^5 is ethyl; and R^6 is methyl), methyl β acetyloxalylamidrazone (a compound wherein R^5 is methyl; and R^6 is methyl), ethyl β propionyloxalylamidrazone (a compound wherein R^5 is ethyl; and R^6 is ethyl), methyl β propionyloxalylamidrazone (a compound wherein R^5 is methyl; and R^6 is ethyl), β formyl oxalylamidrazone (a compound wherein R^5 and R^6 each is hydrogen), β acetyloxalylamidrazone (a compound wherein R^5 is hydrogen; and R^6 is methyl), β propionyloxalylamidrazone (a compound wherein R^5 is hydrogen; and R^6 is ethyl) or the like. Preferred is a compound wherein R^5 is alkyl, especially, ethyl β formyl oxalylamidrazone (a compound wherein R^5 is ethyl; and R^6 is hydrogen) or methyl β formyl oxalylamidrazone

(a compound wherein R^5 is methyl; and R^6 is hydrogen).

Process B4



5 wherein R^5 is optionally substituted alkyl; R^6 is hydrogen, optionally substituted alkyl or optionally substituted aryl; R^{12} is a group of the formula: $-R^7$ wherein R^7 is trityl, optionally substituted sulfamoyl or optionally substituted alkoxymethyl, a group of the formula: $-C(OR^8)R^9-CHR^{10}R^{11}$ wherein R^8 is optionally substituted alkyl; R^9 , R^{10} and R^{11} each is
10 independently hydrogen or optionally substituted alkyl; or R^8 and R^{10} may be taken together to form optionally substituted alkylene, or hydroxy methyl.

This process includes a process for the preparation of a compound (IV-6) which comprises introducing a protecting group (R^{12}) to a compound (IV-5).

15 To a compound (IV-5) was added an organic solvent (e.g., tetrahydrofuran, dimethylformamide). To a compound (IV-5) is added one or more mole equivalent, preferably approximately 1.25 mole equivalent of a compound of the formula: R^7X wherein R^7 is trityl, optionally substituted sulfamoyl or optionally substituted alkoxy methyl; and X is halogen, to a
20 compound (IV-5), if desired, in the presence of one or more mole equivalent, preferably approximately 1.1 mole equivalent of a base (e.g., sodium hydride, N, N-dimethylacetamide) to a compound (IV-5). In another method, to a compound (IV-5) is added one or more mole equivalent, preferably approximately 1.1 mole equivalent of a compound of the formula: $(R^8O)R^9C=$

CR¹⁰R¹¹ wherein R⁸ is optionally substituted alkyl; R⁹, R¹⁰ and R¹¹ each is independently hydrogen or optionally substituted alkyl; or R⁸ and R¹⁰ may be taken together to form optionally substituted alkylene to a compound (IV-5) in the presence of 0.01 - 0.5 mole equivalent, preferably approximately 0.03 mole
5 equivalent of an acid (e.g., methane sulfonic acid, benzene sulfonic acid, p-toluenesulfonic acid, p-toluenesulfonic acid mono hydrate, hydrochloric acid, sulfuric acid, nitric acid) to a compound (IV-5).

The reaction mixture is stirred for 0.5 to 10 hours, preferably approximately 2 hours at room temperature, if desired, under heating. The
10 mixture is extracted, washed, removed under reduced pressure and filtered to give the objective compound (IV-6).

When introducing tetrahydropyran-2-yl as a protecting group, a compound (IV-5) can be reacted with 3,4-dihydro-2*H*-pyran in the presence of an acid in THF. The acid can be used equivalent to a compound (IV-5) or in a
15 catalytic amount. The acid includes p-toluene sulfonic acid, benzene sulfonic acid or the like.

When introducing 1-methoxy-1-methylethyl as a protecting group, a compound can be reacted with 2-methoxypropene in the presence of an acid in THF. The acid can be used equivalent to a compound (IV-5) or in a catalytic
20 amount. The acid includes p-toluene sulfonic acid, benzene sulfonic acid or the like.

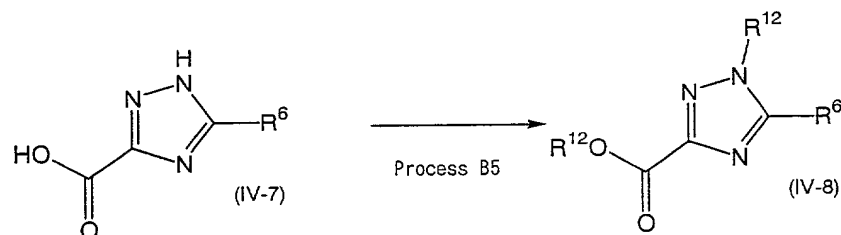
A compound of the formula: R⁷X includes tritylchloride, tritylbromide, methoxymethylchloride, methoxymethylbromide, ethoxymethylchloride, ethoxymethylbromide, sulfamoyl chloride, N,N-dimethylsulfamoyl chloride,
25 sulfamoyl bromide, N,N-dimethylsulfamoyl bromide or the like.

A compound of the formula: (R⁸O)R⁹C=CR¹⁰R¹¹ includes 3,4-dihydro-2*H*-pyran (a compound wherein R⁸ and R¹⁰ are taken together to form

trimethylene; and R⁹ and R¹¹ each is hydrogen), 2-methoxypropenone (a compound wherein R⁸ and R⁹ each is methyl; and R¹⁰ and R¹¹ each is hydrogen), 2-ethoxypropene (a compound wherein R⁸ is ethyl; R⁹ is methyl; and R¹⁰ and R¹¹ each is hydrogen), methylvinyl ether (a compound wherein R⁸ is methyl; and R⁹, R¹⁰ and R¹¹ each is hydrogen), ethylvinyl ether (a compound wherein R⁸ is ethyl; and R⁹, R¹⁰ and R¹¹ each is hydrogen), n-propylvinyl ether (a compound wherein R⁸ is n-propyl; and R⁹, R¹⁰ and R¹¹ each is hydrogen), n-butylvinyl ether (a compound wherein R⁸ is n-butyl; and R⁹, R¹⁰ and R¹¹ each is hydrogen), isobutylvinyl ether (a compound wherein R⁸ is isobutyl; and R⁹, R¹⁰ and R¹¹ each is hydrogen) or the like.

Besides the above process, a hydroxymethyl group can be introduced as a protecting group to a compound (IV-5) by reacting with formaldehyde in accordance with a method described in A.R.Katritzky and K.Akutagawa, J. Org. Chem., 54, 2929 (1989).

Process B5



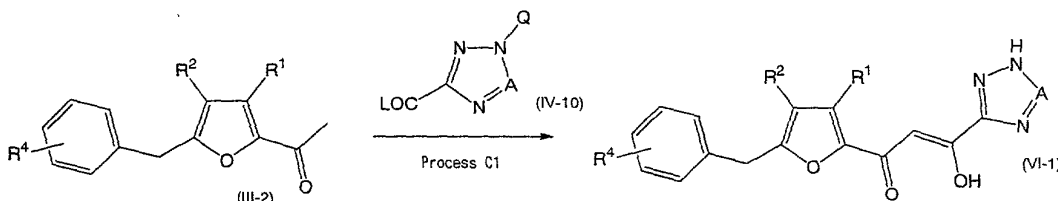
wherein R⁶ is hydrogen, optionally substituted alkyl or optionally substituted aryl; and R¹² is a group of the formula: -R⁷ wherein R⁷ is trityl, optionally substituted sulfamoyl or optionally substituted alkoxy methyl, a group of the formula: -C(OR⁸)R⁹-CHR¹⁰R¹¹ wherein R⁸ is optionally substituted alkyl; R⁹, R¹⁰ and R¹¹ each is independently hydrogen or optionally substituted alkyl; or R⁸ and R¹⁰ may be taken together to form optionally substituted alkylene, or hydroxy group.

This process includes a process for the preparation of a compound (VI-8) which comprises introducing protective groups (R^{12}) at two positions to a compound (IV-7). The introduction of a protecting group at two positions at the same time can reduce the number of steps, thus being efficient and useful for industrial production.

This step can be carried out as well as the above B4) except doubling the amount of a base and a compound of the formula: R^7X , an acid and a compound of the formula: $(R^8O)R^9C=CR^{10}R^{11}$, or formaldehyde.

A process for the preparation of substituted propenone derivatives is explained below.

Process C1



wherein R^1 , R^2 and R^4 each is independently hydrogen, optionally substituted alkyl, optionally substituted alkoxy or halogen; A is CR^6 or N; R^6 is hydrogen, optionally substituted alkyl or optionally substituted aryl; L is a leaving group; and Q is a protecting group.

This scheme shows a process for the preparation of 1-[5-benzylfuran-2-yl]-3-hydroxy-3-(1H-1,2,4-triazole-3-yl)propenone derivatives from 2-acetyl-5-benzylfuran derivatives. This step can be carried out in the presence of a base, and followed by deprotection of a protecting group (Q) on tetrazolyl or triazolyl. In this step, a compound (III-2), a compound (III-1) wherein R^3 is methyl can be used.

A compound of the formula (III-2) includes 2-acetyl-5-benzylfuran, 2-

acetyl-5-(4-methylbenzyl)furan, 2-acetyl-5-(4-methoxybenzyl)furan, 2-acetyl-5-(4-fluorobenzyl)furan, 2-acetyl-5-(4-chlorobenzyl)furan, 2-acetyl-5-(3-methylbenzyl)furan, 2-acetyl-5-(3-methoxybenzyl)furan, 2-acetyl-5-(3-fluorobenzyl)furan, 2-acetyl-5-(3-chlorobenzyl)furan or the like. Preferred is 2-acetyl-5-(4-fluorobenzyl)furan.

A compound of the formula (IV-10) includes 2-trityl-2H-tetrazole-5-carboxylic acid ethyl ester, 1-trityl-1*H*-1,2,4-triazole-3-carboxylic acid methyl ester, 1-trityl-1*H*-1,2,4-triazole-3-carboxylic acid ethyl ester or the like. Preferred is 1-trityl-1*H*-1,2,4-triazole-3-carboxylic acid ethyl ester, 1-trityl-1*H*-1,2,4-triazole-3-carboxylic acid methyl ester.

A protecting group (Q) includes methoxymethyl, dialkoxy methyl, tert-butoxycarbonyl, 9-fluorenylmethoxycarbonyl, tosyl, trityl, allyl, formyl or the like. Moreover, a protecting group includes a group of the formula: -R⁷ wherein R⁷ is trityl, optionally substituted sulfamoyl or optionally substituted alkoxymethyl, a group of the formula: -C(OR⁸)R⁹-CHR¹⁰R¹¹ wherein R⁸ is optionally substituted alkyl; R⁹, R¹⁰ and R¹¹ each is independently hydrogen or optionally substituted alkyl; or R⁸ and R¹⁰ may be taken together to form optionally substituted alkylene, or hydroxy methyl. A deprotection of these protecting groups can be carried out, depending on the kind of protecting groups. The deprotection can be carried out by hydrolysis under an acidic condition or a basic condition.

A leaving group (L) includes alkoxy (methoxy, ethoxy, isopropoxy, tert-butoxy, biphenylmethoxy), heteroaryl (imidazolyl, tetrazolyl), cyano or the like. Preferred is methoxy or ethoxy.

A base includes sodium methoxide, sodium ethoxide, potassium tert-butoxide, n-butyllithium, lithiumbistrimethylsilylamide or the like. Preferred is sodium methoxide.

A reaction solvent includes dimethylformamide, tetrahydrofuran, dioxane, alcohols (e.g., methanol, ethanol, isopropylalcohol) or the like. A mixed solvent can be used as a reaction solvent. Preferred is tetrahydrofuran, methanol or a mixed solvent thereof.

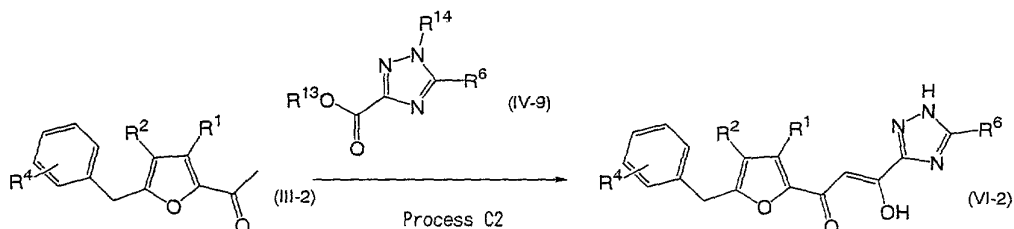
5 A reaction temperature is -100 to 100 °C, preferably -50 to 50 °C.

A reaction time is 1 to 48 hours, preferably 1 to 24 hours.

A compound of the formula (III-2), a compound of the formula (IV-10) and a base can be added in any order. For example, a base may be added to a compound of the formula (III-2), and after a couple of minutes or hours a compound of the formula (IV-10) may be added thereto. As another method, a base (or a solvent comprising a base) may be added dropwise to a mixture of a compound of the formula (III-2) and a compound of the formula (IV-10).

Preferred is a process described in the following C2.

15 Process C2



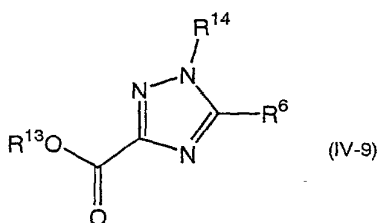
wherein R¹, R² and R⁴ each is independently hydrogen, optionally substituted alkyl, optionally substituted alkoxy or halogen; R⁶ is hydrogen, optionally substituted alkyl or optionally substituted aryl; R¹³ is optionally substituted alkyl, a group of the formula: -R⁷ wherein R⁷ is trityl, optionally substituted sulfamoyl or optionally substituted alkoxymethyl, a group of the formula: -C(OR⁸)R⁹-CHR¹⁰R¹¹ wherein R⁸ is optionally substituted alkyl; R⁹, R¹⁰ and R¹¹ each is independently hydrogen or optionally substituted alkyl; or R⁸ and R¹⁰ may be taken together to form optionally substituted alkylene, or

hydroxymethyl; and R^{14} is a group of the formula: $-R^7$ wherein R^7 is as defined above, a group of the formula: $-C(OR^8)R^9-CHR^{10}R^{11}$ wherein R^8 , R^9 , R^{10} and R^{11} are as defined above, or hydroxymethyl.

This scheme shows a process for the preparation of a compound of the formula (VI-2) which comprises reacting a compound of the formula (IV-9) obtained in process B4 or B5 with a compound of the formula (III-2) in the presence of a base and deprotecting R^{14} on triazole.

A compound of the formula (III-2), a base, a reaction solvent, a reaction temperature and a reaction time are the same as Process C1.

A preferred compound of the formula (IV-9) includes a compound of the formula (IV-9):



wherein R^6 is hydrogen or alkyl; R^{13} is alkyl, a group of the formula: $-R^7$ wherein R^7 is trityl, optionally substituted sulfamoyl or alkoxy methyl, a group of the formula: $-C(OR^8)R^9-CHR^{10}R^{11}$ wherein R^8 is alkyl; R^9 , R^{10} and R^{11} each is independently hydrogen or alkyl; or R^8 and R^{10} may be taken together to form alkylene, or hydroxymethyl; and R^{14} is a group of the formula: $-R^7$ wherein R^7 is as defined above, a group of the formula: $-C(OR^8)R^9-CHR^{10}R^{11}$ wherein R^8 , R^9 , R^{10} and R^{11} are defined above, or hydroxymethyl; provided that a compound wherein R^6 is hydrogen; R^{13} is methyl; and R^{14} is trityl, a compound wherein R^6 is hydrogen; R^{13} is methyl; and R^{14} is tetrahydropyran-2-yl and a compound wherein R^6 is hydrogen; R^{13} is ethyl; and R^{14} is trityl are excluded. More Preferred is a compound wherein R^6 is hydrogen; R^{13} is methyl or ethyl; and R^{14} is tetrahydropyran-2-yl, hydroxymethyl,

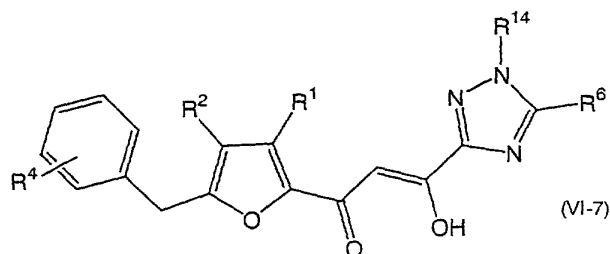
methoxymethyl, ethoxymethyl, N,N-dimethylsulfamoyl, (1-methoxy-1-methyl)ethyl, (1-ethoxy)ethyl, (1-ethoxy-1-methyl)ethyl, (1-n-propoxy)ethyl, (1-n-butoxy)ethyl or (1-isobutoxy)ethyl.

For example, a compound of the formula (IV-9) includes 1-trityl-1*H*-
5 1,2,4-triazole-3-carboxylic acid methyl ester, 1-trityl-1*H*-1,2,4-triazole-3-carboxylic acid ethyl ester, 1-(tetrahydropyran-2-yl)-1*H*-1,2,4-triazole-3-carboxylic acid ethyl ester, 1-hydroxy methyl-1*H*-1,2,4-triazole-3-carboxylic acid ethyl ester, 1-methoxymethyl-1*H*-1,2,4-triazole-3-carboxylic acid ethyl ester, 1-[(1-methoxy-1-methyl)ethyl]-1*H*-1,2,4-triazole-3-carboxylic acid ethyl
10 ester, 1-[(1-ethoxy)ethyl]-1*H*-1,2,4-triazole-3-carboxylic acid ethyl ester, 1-[(1-ethoxy-1-methyl)ethyl]-1*H*-1,2,4-triazole-3-carboxylic acid ethyl ester, 1-[(1-n-propoxy)ethyl]-1*H*-1,2,4-triazole-3-carboxylic acid ethyl ester, 1-[(1-n-butoxy)ethyl]-1*H*-1,2,4-triazole-3-carboxylic acid ethyl ester, 1-trityl-1*H*-1,2,4-triazole-3-carboxylic acid methyl ester, 1-(tetrahydropyran-2-yl)-1*H*-
15 1,2,4-triazole-3-carboxylic acid methyl ester, 1-hydroxy methyl-1*H*-1,2,4-triazole-3-carboxylic acid methyl ester, 1-methoxymethyl-1*H*-1,2,4-triazole-3-carboxylic acid methyl ester, 1-[(1-methoxy-1-methyl)ethyl]-1*H*-1,2,4-triazole-3-carboxylic acid methyl ester, 1-[(1-ethoxy)ethyl]-1*H*-1,2,4-triazole-3-carboxylic acid methyl ester, 1-[(1-ethoxy-1-methyl)ethyl]-1*H*-1,2,4-triazole-3-carboxylic acid methyl ester, 1-[(1-n-propoxy)ethyl]-1*H*-1,2,4-triazole-3-carboxylic acid methyl ester, 1-[(1-n-butoxy)ethyl]-1*H*-1,2,4-triazole-3-carboxylic acid methyl ester or the like.

This process can be carried out as shown below. In an organic solvent (e.g., tetrahydrofuran, dioxane, diethylether) is dissolved a compound of the
25 formula (III-2). 1.0 to 3.0 mole equivalent, preferably approximately 2 mole equivalent of a base described above to a compound of the formula (III-2) is added thereto at -80 to -10 °C, preferably -30 to -25 °C. The mixture is

stirred at the same temperature for 1 to 10 hours, preferably approximately
 1.5 hours. A solution of a compound of the formula (IV-9) in an organic
 solvent (e.g., tetrahydrofuran, dioxane, diethyl ether) is added thereto at -80
 to -5 °C (preferably, -32 to -7 °C). The mixture is warmed up to the room
 5 temperature (approximately 25 °C) and stirred for 1 to 10 hours
 (approximately 2 hours). After that, the reaction mixture is poured into an
 acid (e.g., dilute hydrochloric acid) for neutralizing excess of a base, extracted
 with an organic solvent (e.g., methylene chloride, chloroform, ethylacetate),
 washed with water, concentrated under reduced pressure and filtered to give
 10 a crystal.

A protected derivative includes a compound of the formula (IV-7):



wherein R¹, R² and R⁴ each is independently hydrogen, optionally substituted
 alkyl, optionally substituted alkoxy or halogen; R⁶ is hydrogen, optionally
 15 substituted alkyl or optionally substituted aryl; and R¹⁴ is a group of the
 formula: -R⁷ wherein R⁷ is trityl, optionally substituted sulfamoyl or
 optionally substituted alkoxy methyl, a group of the formula: -C(OR⁸)R⁹-
 CHR¹⁰R¹¹ wherein R⁸ is alkyl; R⁹, R¹⁰ and R¹¹ each is independently hydrogen
 or optionally substituted alkyl; or R⁸ and R¹⁰ may be taken together to form
 20 alkylene, or hydroxymethyl. Preferred is a compound wherein R⁴ is 4-fluoro;
 R¹, R² and R⁶ each is hydrogen; and R¹⁴ is trityl, tetrahydropyran-2-yl,
 hydroxymethyl, methoxymethyl, ethoxymethyl, N,N-dimethylsulfamoyl, (1-
 methoxy-1-methyl)ethyl, (1-ethoxy)ethyl, (1-ethoxy-1-methyl)ethyl, (1-n-

propoxy)ethyl, (1-n-butoxy)ethyl or (1-isobutoxy)ethyl.

To a suspension of a crystal in an organic solvent (e.g., ethanol, dioxane) is added for removing a protecting group (R^{14} on triazole) 0.01 - 10.0 mole equivalent, preferably 0.1 - 5.0 mole equivalent of an acid (e.g., hydrochloric acid, sulfuric acid, nitric acid) or a base (e.g., potassium carbonate, sodium hydroxide, potassium hydroxide, sodium hydrogencarbonate, sodium carbonate, sodium methoxide, sodium ethoxide) to a compound of the formula (III-2). The mixture is stirred at 0 to 100 °C (preferably 20 to 70 °C) for 1 to 10 hours (e.g., approximately 1 hour). An acid or a base can be used as a catalyst, which depends on a kind of protecting groups. When 1-methoxy-1-methylethyl group is used as a protecting group, it can be removed by using a catalytic amount of sulfuric acid.

When a base is used as a deprotecting agent, the objective compound of the formula (VI-2) can be obtained by cooling the reaction mixture and filtering the precipitated crystal.

When an acid is used as a deprotecting agent, a compound of the formula (VI-2) forms a salt with an acid. Therefore, the objective compound of the formula (VI-2) can be obtained by cooling the reaction mixture, adding 1.0 - 4.0 mole equivalent, preferably approximately 3.0 mole equivalent of a base (e.g., sodium hydroxide, potassium hydroxide, sodium carbonate, sodium hydrogencarbonate) for neutralizing excess of an acid to form a acid-free crystal, and filtering the precipitated crystal.

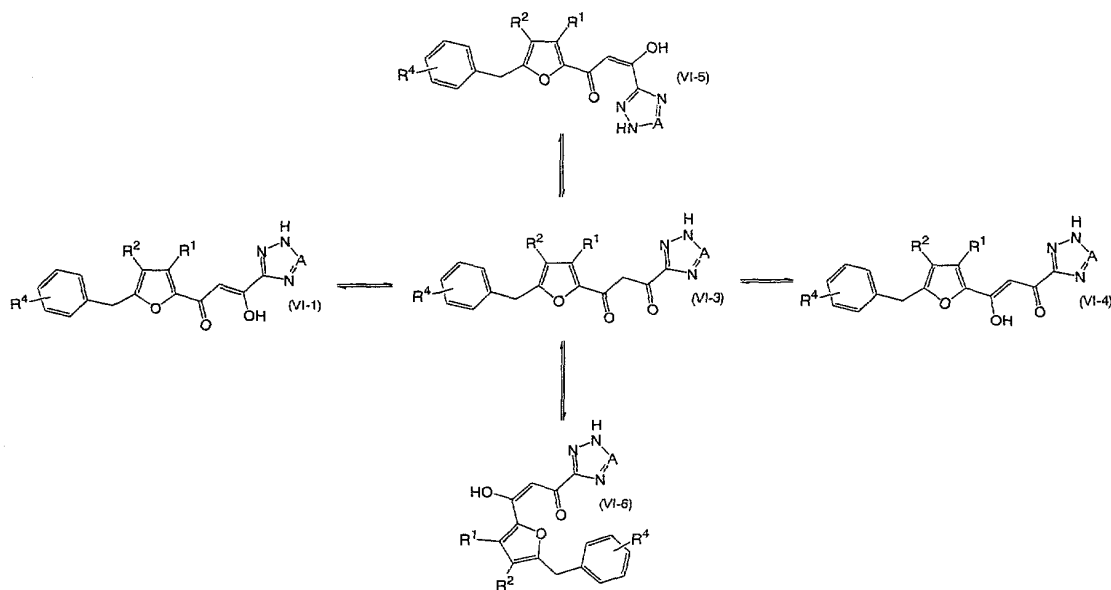
Impurities or the like can be removed by isolating a crystal as a salt. The obtained salt can be changed to a free form by adding a basic aqueous solution or the like after drying or without drying.

The obtained salt can be changed to a free form by adding to an aqueous solution or THF containing water without neutralizing it with a base,

which depends on a kind of acids.

Preferred as a salt is a salt with hydrochloride or the like.

The obtained propenone derivatives can form keto-enol isomers or cis-trans isomers as shown below. In a solution, these isomers are at the equilibrium. Each isomer can be isolated as a crystal by selecting a crystallizing condition (e.g., crystallizing solvent, crystallizing temperature, time).



wherein A is CR⁶ or N; R⁶ is hydrogen, optionally substituted alkyl or optionally substituted aryl; and R¹, R² and R⁴ each is independently hydrogen, optionally substituted alkyl, optionally substituted alkoxy or halogen.

In the present specification, a compound of the formula (VI-1) includes all of the above isomers. On the other hand, an isomer having a structure of the formula (VI-1) means an isomer having a specific structure represented by the formula (VI-1).

When a compound of the formula (VI-1) is 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1H-1,2,4-triazole-3-yl)propenone (a compound of the

formula (VI-1) wherein R^1 and R^2 each is hydrogen; R^4 is p-fluoro; and A is CH), the following three crystals (type I, type II and type III) can be obtained.

A Crystal (type I)

5 It is determined by single crystal X-ray diffraction that a crystal (type I) is an isomer having a structure of the formula (VI-1). A crystal (type I) can be obtained by generally known crystallizing methods. For example, a crystal (type I) can be obtained by dissolving a compound of the formula (VI-1) in a warmed organic solvent, removing impurities by a plaited filter paper
10 and cooling the solution. Any organic solvent, as far as a compound of the formula (VI-1) can be dissolved, can be used, for example, an organic solvent such as tetrahydrofuran, dimethylformamide, ethanol, methanol, isopropanol, ether, isopropylether, ethylacetate, methylene chloride, chloroform, dioxane or the like, a mixed solvent thereof (e.g., tetrahydrofuran/ethanol) or a solvent
15 containing water (e.g., tetrahydrofuran/water). Considering a crystallizing yield or the like, preferred is an organic solvent, the solubility thereto much depends on temperature.

A crystal (type II)

20 It is determined by single crystal X-ray diffraction that a crystal (type II) is an isomer having a structure of the formula (VI-4). A crystal (type II) can be obtained by dissolving a compound of the formula (VI-1) in an organic solvent at a lower concentration than that for obtaining a crystal (type I) and keeping it for several hours to several days. Preferred as an organic solvent
25 for obtaining a crystal (type II) is an organic solvent which can gradually be vaporized even at room temperature (e.g., ethylacetate). A crystal (type II) can be precipitated by dissolving a compound of the formula (VI-1) in an

organic solvent and naturally vaporizing the solvent at room temperature for several hours or several days.

A crystal (type III)

5 It is determined by powder X-ray diffraction, infrared absorption spectrum and differential scanning calorimetry that this crystal is different from the above crystal (type I) and (type II). A crystal (type III) can be obtained by adding an alcohol (e.g., methanol, ethanol) or the like to a hydrochloride of a compound of the formula (VI-1) under heating and stirring, 10 concentrating the alcohol under reduced pressure, adding an alcohol, repeating the same steps and filtering the precipitated crystal.

These crystals (type I), (type II) and (type III) are at the equilibrium in vivo and have anti-HIV activities. Therefore, all crystals are useful as anti- 15 HIV agents.

Among these crystals (type I), (type II) and (type III), preferred is a crystal (type I), because it can easily be prepared and stably be provided.

These crystals can be identified by single crystal X-ray diffraction, 20 powder X-ray diffraction, infrared absorption spectrum and differential scanning calorimetry. Each crystal can be identified by these instrumental analysis.

A crystalline substance can be identified by crystal parameter of single crystal X-ray diffraction such as unit cell constants and its space group. 25 Unit cell constants are represented by lengths of its side faces, relative angles between its side faces and volume of itself. The lengths of its side faces are represented by a, b and c. The relative angles between its side faces are

determined by α , β and γ . The volume of itself is determined by V . A unit cell is precisely explained in X-Ray Structure Determination; A Practical Guide, Macmillan, Staut and Jensen, New York (1968). Single crystal X-ray diffraction can be performed under the condition of $\text{CuK}\alpha$, 1.54 Å (monochrometer), voltage 60kV and electricity 300mA. A measuring data includes experimental errors. For example, a data that $a = 32.432(2)$ Å means that $a = 32.432 \pm 0.002$ Å, and generally includes that $a = 32.432 \pm 0.002 \times 3$ Å. Even if such experimental errors are put under consideration, characteristic peaks of single crystal X-ray diffraction of the above crystals are different from each other. Therefore, each crystal can be identified.

In powder X-ray diffraction, measuring peaks may include more or less experimental errors, which depend on a measuring equipment or measuring condition. For example, a data of a diffraction angle (2θ) may include experimental errors of approximately ± 0.2 , and even if using very precise equipment, may include experimental errors of approximately ± 0.1 . Therefore, experimental errors can be considered for identifying each crystal. Even if such experimental errors are taken into consideration, characteristic peaks of powder X-ray diffraction of the above crystals are different from each other. Therefore, each crystal can easily be identified. Powder X-ray diffraction can be performed under the condition of $\text{CuK}\alpha$, 1.54 Å (monochrometer), voltage 40kV and electricity 40mA.

Each crystal can be identified by its characteristic absorption band of an infrared absorption spectrum. The absorption band may include a few experimental errors, which depend on measuring assemblies, measuring conditions and measuring methods such as a film method, a solution method, a nujol mull method and a KBr method. In a solution method, the absorption band may include a few experimental errors, which depend on a solvent to be

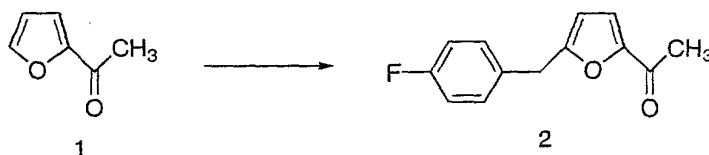
used (e.g., CCl₄, CS₂, CHCl₃, CH₂Cl₂). When the structure of each crystal is identified, an experimental error should be considered. Even if an experimental error is considered, each characteristic absorption band and fingerprint region of each crystal are different from each other. Therefore, each crystal can be identified.

In differential scanning calorimetry, each crystal has its own characteristic peaks. These characteristic peaks can be determined by the obtained measuring charts. Each crystal can be identified by peaks (melting points) or change of energy of mass unit of a sample (ΔH). Approximately 1 to 3 mg of a sample is used for measuring. A scanning speed is 10.0 °C/min. A measuring can be performed between 25.0 to 200 °C.

Example

Examples of the above processes A to C are shown below. The scope of the present invention should not be limited to these examples.

Example 1 A process for the preparation of 2-acetyl-5-(4-fluorobenzyl)furan



Example 1(1) Example of using methylene chloride as a reaction solvent.

To a solution of 19.71 g (0.18 mol) of 2-acetylfuran in 120 ml of methylene chloride were added 42.9 ml (2.0 eq) of 4-fluorobenzylchloride and 36.6 g (1.5 eq) of zinc chloride. The mixture was refluxed for 12 hours. The precipitated crystal was filtered and washed with methylene chloride. The obtained solid was dissolved in water and extracted with ethylacetate. The organic layer was washed with water and a diluted aqueous solution of sodium

hydrogencarbonate and dried over sodium sulfate. The solvent was evaporated under reduced pressure. The residue was recrystallized from n-hexane to give 16.4 g of 2-acetyl-5-(4-fluorobenzyl)furan. Yield: 42 %. Mp: 27 - 29 °C.

5 ¹H NMR δ (CDCl₃) : 2.43 (s, 3H), 4.01 (s, 2H), 6.09 (d, *J* = 3.5 Hz, 1H), 6.96-7.26 (m, 5H)

Example 1(2) Example without a reaction solvent

A mixture of 9.2 g (83.4 mmol) of 2-acetylfuran, 20 ml (2.0 eq) of 4-fluorobenzylchloride and 22.8 g (2.0 eq) of zinc chloride were stirred at 25 °C
10 for 20 hours. The stirring gradually became difficult due to the precipitate. The mixture was dissolved in water and extracted with ethylacetate. The organic layer was washed with water and a diluted sodium hydrogencarbonate aqueous solution and dried over sodium sulfate. The solvent was removed under deduced pressure. A fractional distillation under reduced pressure of
15 the residue gave 9.6 g of 2-acetyl-5-(4-fluorobenzyl)furan. Yield: 53 %. 2 mmHg/120 - 125 °C.

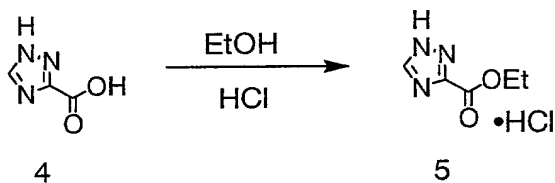
Example 1(3) Example of using water as a reaction solvent.

To 258 g (0.94 mol) of a 50 % aqueous solution of zinc chloride were added 69.3 g of water, 99.0g (0.90 mol) of 2-acetylfuran and 260 g (1.80 mol) of
20 4-fluorobenzylchloride. The mixture was stirred at 85 °C for 6 hours. The reaction mixture was cooled and extracted with ethylacetate. The extract was washed with 1N hydrochloric acid, washed with an aqueous sodium hydrogencarbonate solution and removed under reduced pressure. The obtained residue was distilled under reduced pressure to give 145.4 g of crude
25 2-acetyl-5-(4-fluorobenzyl)furan (106 - 121 °C/0.4mmHg). The crude product was recrystallized from isopropylalcohol/n-hexane to give 84.4 g of 2-acetyl-5-(4-fluorobenzyl)furan. Yield: 43%.

at approximately 5 °C for 30 minutes. The obtained suspension was filtered and washed with 15 ml of ice water. The obtained crystal was dried with heating at 40 °C under reduced pressure to give 2.16 g of 1*H*-1,2,4-triazole-3-carboxylic acid (2). Yield: 95.6 %.

5 Mp: 145 - 150 °C.

Example 3 A process for the preparation of 1*H*-1,2,4-triazole-3-carboxylic acid ethyl ester hydrochloride.



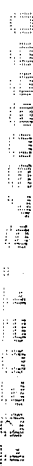
10 To 10 ml of a solution of 1.00 g (8.85 mmol) of 1*H*-1,2,4-triazole-3-carboxylic acid in 99.5% ethanol was added dropwise under stirring and cooling at 5 °C 1.58 g (13.2 mmol) of thionylchloride. The mixture was stirred under heating at 70 °C for 4 hours. Then, the solvent was removed under reduced pressure and the obtained residue was washed with 18 ml of
15 ethylacetate. The obtained crystal was dried at room temperature under reduced pressure to give 1.00 g of 1*H*-1,2,4-triazole-3-carboxylic acid ethyl ester hydrochloride. Yield: 63.7 %.

Mp: 115 - 120 °C.

¹H NMR(d6-DMSO) δ 1.26(t, 3H, J=7.2Hz) 4.28(q,2H, J=7.2Hz) 8.61(s, 1H)
20 9.19(s,2H)

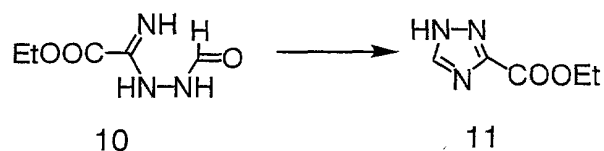
¹³C NMR(d6-DMSO) δ 14.0, 60.8, 142.8, 145.6, 159.09

Example 4 A process for the preparation of ethyl β-formyl oxalamidrazone.



20 β formyl oxalamidrazone. Yield: 56.2 %.

acid ethyl ester.



Example 5(1) In the presence of ortho triethylformate.

To 130.97 g (0.82 mol) of ethyl β formyl oxalamidrazone were added 243.9 g (1.64 mol) of ortho triethylformate and 1310 ml of toluene. The mixture was refluxed at oil bath (110 - 120 °C) for 2.5 hours. After that, a side product, ethanol was removed approximately 200 g under usual pressure before the temperature of the mixture became approximately 100 °C. The concentrated solution was cooled and the crystal was precipitated at 5 - 10 °C for 1 hour. The precipitated crystal was filtered, washed with 249 ml of iced toluene and dried with heating at 45 °C under reduced pressure to give 112 g of 1*H*-1,2,4-triazole-3-carboxylic acid ethyl ester. Yield: 96.8 %.

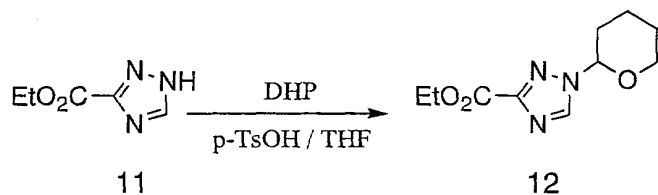
Mp: 180 - 182 °C.

¹H NMR(CDCl₃) δ 1.30(t, 3H, J=6.9Hz) 4.22(q, 2H, J=6.9Hz) 8.66(s, 1H)

Example 5(2) Example in the presence of p-toluenesulfonic acid.

A mixture of 500 mg (3.42 mmol) of ethyl β formyl oxalamidrazone, 60 mg (0.32 mmol) of p-toluenesulfonic acid monohydrate and 1 ml of DMF were stirred with heating at 120 °C for 3 hours. The mixture was cooled at room temperature. 10 ml of toluene was added thereto and stirred under ice cooling for 1.5 hours. The precipitated crystal was filtered, washed with 9 ml of iced toluene and dried with heating 45 °C under reduced pressure to give 389 mg of 1*H*-1,2,4-triazole-3-carboxylic acid ethyl ester. Yield: 87.8 %.

Example 6 A process for the preparation of 1-(tetrahydropyran-2-yl)-1,2,4-triazole-3-carboxylic acid ethyl ester.



Example 6(1) Example of using p-toluenesulfonic acid.

To a suspension of 1.25 g (8.86 mmol) of 1*H*-1,2,4-triazole-3-carboxylic acid ethyl ester in 4 ml of THF was added 51 mg (0.27 mmol) of p-toluenesulfonic acid monohydrate. To the suspension was added at room temperature with stirring 1 ml (11 mmol) of 3,4-dihydro-2*H*-pyran. The mixture was stirred at room temperature for 2 hours and extracted with 15 ml of ethylacetate. The extract was washed with a saturated aqueous solution of sodium hydrogencarbonate and dried over Na₂SO₄. The solvent was concentrated under reduced pressure to give 1.98 g of an oil. The obtained oil was purified with silica gel chromatography (eluate: ethylacetate) to give 1.81 g of 1-(tetrahydropyran-2-yl)-1,2,4-triazole-3-carboxylic acid ethyl ester as colorless oil. Yield: 91 %.

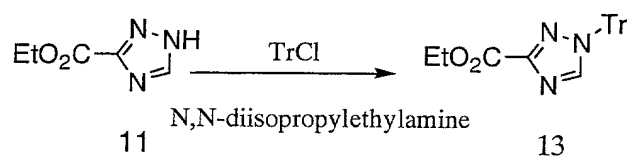
NMR(CDCl₃) δ 1.43(t,3H,J=7.2Hz) 1.66-1.74(m,3H) 2.01-2.05(m,2H) 2.21-2.25(m,1H) 3.72-3.77(m,1H) 4.07-4.11(m,1H) 4.48(q,2H,J=7.2Hz) 5.54(dd,1H,J=2.7, 9.0Hz) 8.37(s,1H)

IR(neat) 1738 cm⁻¹

Example 6(2) Example of using benzene sulfonic acid.

1-(Tetrahydropyran-2-yl)-1,2,4-triazole-3-carboxylic acid ethyl ester was obtained by using a catalytic amount of benzene sulfonic acid in place of p-toluenesulfonic acid monohydrate in Example 6(1).

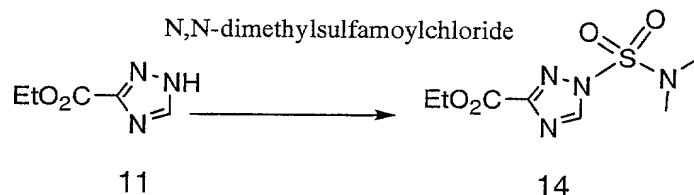
Example 7 A process for the preparation of 1-trityl-1,2,4-triazole-3-carboxylic acid ethyl ester.



In 60 ml of DMF was dissolved 7.62 g (54 mmol) of 1*H*-1,2,4-triazole-3-carboxylic acid ethyl ester. To the solution were added at room temperature 14 g (108 mmol) of N,N-diisopropylethylamine and 15.8 g (56.7 mmol) of tritylchloride. The mixture was stirred for 2 hours. 300 ml of water and 300 ml of ethylacetate were added thereto. The crystal was filtered, dissolved in 150 ml of chloroform, washed with water and dried. The solvent was removed. The residue was crystallized from ether to give 8.91 g of the titled compound. The ethylacetate layer was washed with water, dried and evaporated. The residue was crystallized from ether to give 4.73 g of the titled compound. 13.64 g of 1-trityl-1,2,4-triazole-3-carboxylic acid ethyl ester was totally obtained. Yield: 66 %.

NMR(CDCl₃) δ: 1.41(3H, t, J=7.2Hz), 4.45(2H, q, J=7.2Hz), 7.11-7.13(6H, m), 7.32-7.36, 8.01(1H, s).

Example 8 Process for the preparation of 1-(N,N-dimethylsulfamoyl)-1,2,4-triazole-3-carboxylic acid ethyl ester.



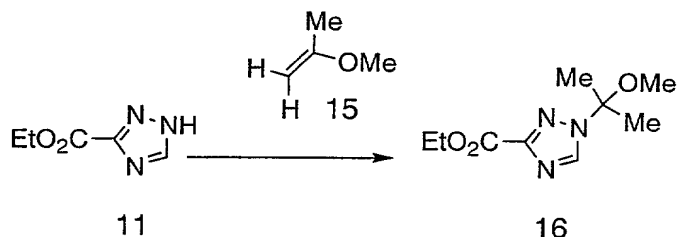
To a solution of 1.02 g (7.23 mmol) of 1*H*-1,2,4-triazole-3-carboxylic acid ethyl ester in 6 ml of DMF was added 1.46 g (1.44 mmol) of triethylamine. To the solution was added dropwise with stirring under ice-cooling 1.14 g (7.94 mmol) of dimethylsulfamoyl chloride. The mixture was stirred at room

temperature for 8 hours. 30 ml of Water was added thereto and extracted with 20 ml of ethylacetate. The extract was washed with a saturated aqueous solution of sodium hydrogencarbonate and water, dried over Na₂SO₄ and evaporated under reduced pressure to give an oil. The obtained oil was
 5 purified with silica gel chromatography (eluate: hexane/ethylacetate=2:1) to give 1.46 g of 1-dimethylsulfamoyl-1,2,4-triazole-3-carboxylic acid ethyl ester as a white crystal. Yield: 82 %.

Mp: 78.5 - 81.5 °C.

NMR(CDCl₃) δ 1.44(t,3H,J=7.2Hz) 3.06(s,6H) 4.50(q,2H,J=7.2Hz) 8.63(s,1H)

Example 9(1) A process for the preparation of 1-(1-methoxy-1-methylethyl)-
 1*H*-1,2,4-triazole-3-carboxylic acid ethyl.



To a slurry of 0.71 g (5 mmol) of 1*H*-1,2,4-triazole-3-carboxylic acid
 15 ethyl ester in 3.5 ml of THF was added 26 mg (3 mol%) of benzene sulfonic acid monohydrate. 0.72 g (10 mmol) of 2-methoxypropene was added dropwise thereto under ice cooling. The mixture was stirred at room temperature for 2 hours. The reaction mixture was extracted with 15 ml of ethylacetate, washed with a saturated aqueous solution of sodium bicarbonate, dried over
 20 MgSO₄ to give yellow oil. The oil was purified with silica gel chromatography (eluate: hexane/ethylacetate=1:1) to give 0.50 g of 1-(1-methoxy-1-methylethyl)-1*H*-1,2,4-triazole-3-carboxylic acid ethyl as a pale yellow oil. Yield: 47 %.

NMR(CDCl₃) δ 1.44(t,3H J=7.2Hz) 1.84(s,6H) 3.20(s,3H) 4.49(q,2H J=7.2Hz)

8.38(s,1H)

HPLC tR=26.7min

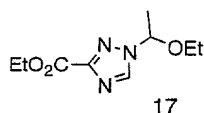
Column : Inertsil ODS-3 (5 μ m) 4.6 \times 250mm

Mobile Phase: phosphate buffer (pH7)/acetonitrile (85:15)

5 Flow Rate : 1.0mL/min Detector : 205nm

Compounds described in the following Example 9(2) to 9(5) were prepared in accordance with the same manner of Example 9(1).

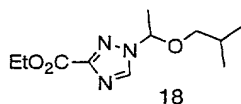
Example 9(2) 1-(1-Ethoxyethyl)-1*H*-1,2,4-triazole-3-carboxylic acid ethyl.



NMR(CDCl₃) δ 1.20(t,3H J=7.2Hz) 1.45(t,3H J=7.2Hz) 1.73 (d,3H J=6.0Hz) 3.41-3.62(m,2H) 4.50(q,2H J=7.2Hz) 5.69(q,1H J=6.0Hz) 8.36(s,1H)

Mp: 59 - 60 °C.

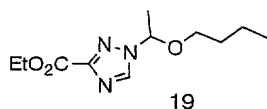
15 Example 9(3) 1-(1-Isobutoxyethyl)-1*H*-1,2,4-triazole-3-carboxylic acid ethyl.



NMR(CDCl₃) δ 0.87(d,3H J=6.9Hz) 0.88(d,3H J=6.9Hz) 1.45(t,3H J=7.2Hz) 1.73 (d,3H J=6.0Hz) 1.77-1.90(m,1H) 3.14(dd,1H J=6.6, 9.0Hz) 3.28(dd,1H J=6.6, 9.0Hz) 4.49(q,2H J=7.2Hz) 5.66 (q,1H J=6.0Hz) 8.34(s,1H)

20 Mp: 67 °C.

Example 9(4) 1-(1-Butoxyethyl)-1*H*-1,2,4-triazole-3-carboxylic acid ethyl.

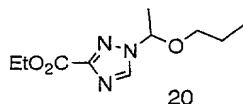


NMR(CDCl₃) δ 0.88(t,3H J=6.9Hz) 1.25-1.40(m,2H) 1.45(t,3H J=7.2Hz) 1.45-

1.60 (m,2H) 1.73(d,3H J=6.0Hz) 3.34-3.42 (m,1H) 3.46-3.54 (m,1H) 4.50(q,2H J=7.2Hz) 5.67 (q,1H J=6.0Hz) 8.35(s,1H)

Mp: 42 - 43 °C.

5 Example 9(5) 1-(1-Propoxyethyl)-1*H*-1,2,4-triazole-3-carboxylic acid ethyl.

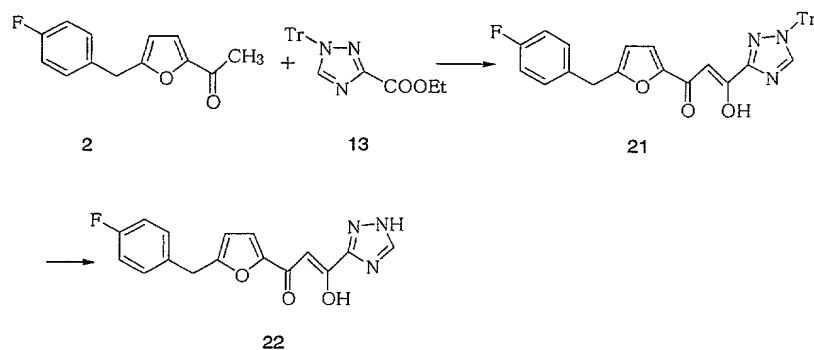


NMR(CDCl₃) δ 0.89(t,3H J=6.9Hz) 1.45(t,3H J=7.2Hz) 1.45-1.60 (m,2H) 1.73(d,3H J=6.0Hz) 3.34-3.42 (m,1H) 3.46-3.54 (m,1H) 4.50(q,2H J=7.2Hz) 5.67 (q,1H J=6.0Hz) 8.35(s,1H)

Mp: 31 - 32 °C.

Example 10 A process for the preparation of 1-[5-(4-Fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propenone.

15 Example 10(1) Example of using trityl as a protecting group.



To a solution of 624 g (2.86 mol) of 5-(4-fluorobenzyl)-2-acetylfuran in 3.0 L of tetrahydrofuran was added at -32 to -25 °C 5.72 L (2.0 eq) of a solution of 1.0 M lithium bis(trimethylsilyl)amide in tetrahydrofuran. The mixture was stirred at the same temperature for 1.5 hours. 11.2 L of a solution of 1.26 kg (1.15 eq) of 1-trityl-3-ethoxycarbonyl-1,2,4-triazole in tetrahydrofuran

was added thereto at -32 to -7 °C. The reaction mixture was stirred at 25 °C for 2 hours, poured into diluted hydrochloric acid and extracted with ethylacetate. The organic layer was washed with water and evaporated under reduced pressure to give a slurry. The crystal was filtered to give 1.53 kg of a protective form. Yield: 95.8 %.

The crystal was suspended in 7.5 L of dioxane and mixed with 2.74 L (3.0 eq) of 1.5 N hydrochloric acid. The mixture was stirred at 70 °C for 1 hour. After cooling, 2.74 L (3.0 eq) of 1.5 N sodium hydroxide was added thereto and the precipitated crystal was filtered. The crystal was suspended in ethylacetate and dissolved in a diluted aqueous solution of sodium hydroxide. After the separation of water layer, an aqueous solution was acidified with concentrated hydrochloride to pH 4. The precipitated crystal was filtered and recrystallized from tetrahydrofuran/ethylalcohol to give 548 g of the titled compound. Yield: 64 %.

Mp: 183 - 185 °C.

Elementary analysis for $C_{16}H_{12}FN_3O_3$

Calcd (%): C, 61.34; H, 3.86; N, 13.41; F, 6.06.

Found (%): C, 61.22; H, 3.72; N, 13.41; F, 6.03.

NMR(d_6 -DMSO) δ 4.15(2H, s), 6.47(1H, d, $J=3.3$ Hz), 6.93(1H, s), 7.17(2H, t, $J=9.0$ Hz), 7.31-7.37(2H, m), 7.50(1H, d, $J=3.3$ Hz), 8.70(1H, brs).

Example 10(2) Example of using tetrahydropyran-2-yl as a protecting group.



A mixture of 0.40 g (1 mmol) of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-[1-(tetrahydropyran-2-yl)-1,2,4-triazole-3-yl]propenone, 2 ml of 1 N diluted hydrochloric acid and 2 ml of methanol was stirred at 75 °C for 2 hours. The reaction mixture was cooled to room temperature and stirred under ice

cooling for 15 minutes. The precipitated crystal was filtered and washed with methanol to give 0.29 g of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propenone as a pale yellow crystal. Yield: 93 %.

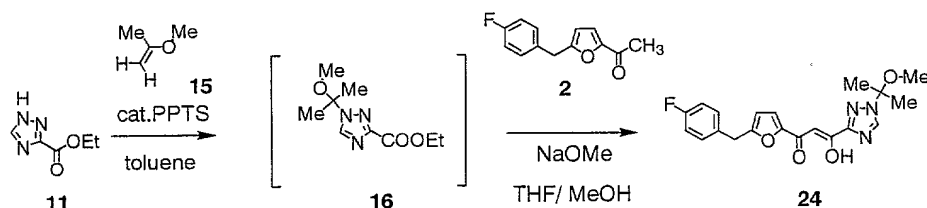
5 Example 10(2-2)

10 1-[5-(4-Fluorobenzyl)furan-2-yl]-3-hydroxy-3-[1-(tetrahydropyran-2-yl)-1,2,4-triazole-3-yl]propenone was prepared in accordance with the same method of Example 10(2-1) and reacted with concentrated hydrochloric acid/isopropylalcohol to isolate 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propenone hydrochloride. The obtained hydrochloride salt was dissolved in aqueous THF. The precipitated crystal was filtered to give 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propenone.

15 Example 10(2-3)

1-[5-(4-Fluorobenzyl)furan-2-yl]-3-hydroxy-3-[1-(tetrahydropyran-2-yl)-1,2,4-triazole-3-yl]propenone was prepared in accordance with the same method of Example 10(2-1), reacted with concentrated hydrochloric acid/methanol to isolate 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propenone hydrochloride. The obtained hydrochloride salt was dissolved in aqueous THF and neutralized with one mole equivalent of sodium carbonate. The precipitated crystal was filtered to give 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propenone.

25 Example 11(1) Process for the preparation of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-[1-(1-methoxy-1-methylethyl)-1*H*-1,2,4-triazole-3-yl]propenone.



A slurry of 7.06 g (50 mmol) of 1*H*-1,2,4-triazole-3-carboxylic acid ethyl ester in 35 ml of toluene was added 0.38 g (3 mol%) of *p*-toluenesulfonic acid pyridinium salt monohydrate. 4.69 g (65 mmol) of 2-methoxypropene was added dropwise at room temperature thereto. The mixture was stirred at 45 °C for 2 hours. After that, 10.91 g (50 mmol) of 2-acetyl-5-(4-fluorobenzyl)furan and 35 ml of THF were added thereto and then 13.5 ml (65 mmol) of a 28 % solution of sodium methoxide in methanol was added dropwise under ice-cooling. The reaction mixture was warmed up to 60 °C and stirred for 3 hours. The reaction mixture was cooled to room temperature and kept standing overnight. To the solution was added dropwise under ice cooling 28.5 g of a 13.7 % solution of acetic acid. The organic layer was separated. The extract was washed with 28.5 g of 5 % brine, concentrated at 45 °C under 50 mmHg to give 26.71 g of an oil. The residue was crystallized from 42 ml of isopropylalcohol to give 14.58 g of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-[1-(1-methoxy-1-methylethyl)-1*H*-1,2,4-triazole-3-yl]propanone as yellow crystal. Yield: 75.7 %.

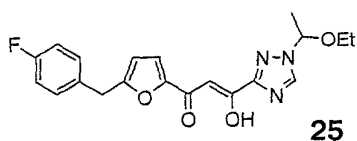
NMR(CDCl₃) δ 1.86(s,6H) 3.22(s,3H) 4.05(s,2H) 6.16(d,1H, J=3.3Hz) 6.99-7.05(m,2H) 7.02(s,1H) 7.20-7.25(m,3H) 8.38(s,1H)

Mp: 111 °C.

The following compounds described in Example 11(2) to 11(5) were prepared in accordance with the same manner of Example 11(1).

Example 11(2) 1-[5-(4-Fluorobenzyl)furan-2-yl]-3-hydroxy-3-[1-(1-

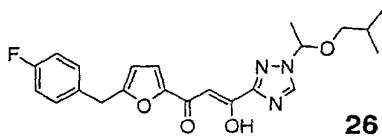
ethoxyethyl)-1*H*-1,2,4-triazole-3-yl]propenone.



NMR(CDCl₃) δ 1.20(t, 3H J=7.2Hz) 1.75(d, 3H J=6.0Hz) 3.44-3.63(m, 2H)
4.05(s, 2H) 5.69 (q, 1H J=6.0Hz) 6.16 (d, 1H J=3.3Hz) 6.99-7.05(m, 2H)
5 7.02(s, 1H) 7.20-7.26(m, 3H) 8.35(s, 1H)

Mp: 85 - 87 °C.

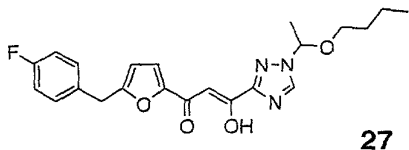
Example 11(3) 1-[5-(4-Fluorobenzyl)furan-2-yl]-3-hydroxy-3-[1-(1-isobutoxyethyl)-1*H*-1,2,4-triazole-3-yl]propenone.



NMR(CDCl₃) δ 0.88(d, 3H J=6.6Hz) 0.89(d, 3H J=6.6Hz) 1.75(d, 3H J=6.0Hz)
1.78-1.91(m, 1H) 3.17(dd, 1H J=6.6, 9.0Hz) 3.29(dd, 1H J=6.6, 9.0Hz) 4.05(s, 2H)
5.66 (q, 1H J=6.0Hz) 6.16 (d, 1H J=3.3Hz) 6.99-7.05(m, 2H) 7.02(s, 1H) 7.20-
7.25(m, 3H) 8.34(s, 1H)

Mp: 70 °C.

Example 11(4) 1-[5-(4-Fluorobenzyl)furan-2-yl]-3-hydroxy-3-[1-(1-butoxyethyl)-1*H*-1,2,4-triazole-3-yl]propenone.

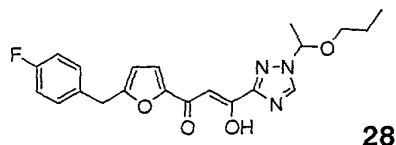


NMR(CDCl₃) δ 0.89(t, 3H J=7.2Hz) 1.27-1.37(m, 2H) 1.50-1.59(m, 2H) 1.75(d, 3H
J=6.0Hz) 3.47-3.53(m, 2H) 4.05(s, 2H) 5.67 (q, 1H J=6.0Hz) 6.16 (d, 1H J=3.3Hz)

6.99-7.05(m,2H) 7.02(s,1H) 7.20-7.26(m,3H) 8.34(s,1H)

IR(neat) = 3117, 2960, 2935, 2874, 1736, 1714, 1606 cm^{-1}

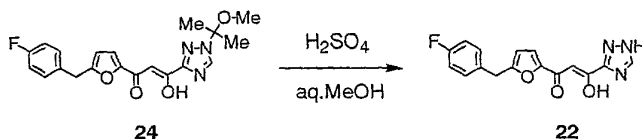
Example 11(5) 1-[5-(4-Fluorobenzyl)furan-2-yl]-3-hydroxy-3-[1-(1-propoxyethyl)-1*H*-1,2,4-triazole-3-yl]propenone.



NMR(CDCl_3) δ 0.90(t,3H $J=7.2\text{Hz}$) 1.53-1.65(m,2H) 1.75(d,3H $J=6.0\text{Hz}$) 3.33-3.41(m,1H) 3.44-3.52(m,1H) 4.05(s,2H) 5.68 (q,1H $J=6.0\text{Hz}$) 6.16 (d,1H $J=3.3\text{Hz}$) 6.99-7.05(m,2H) 7.02(s,1H) 7.20-7.25(m,3H) 8.35(s,1H)

10 Mp: 67 - 68 $^{\circ}\text{C}$.

Example 12 1-[5-(4-Fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propenone.



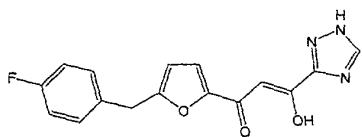
15 A solution of 4 g (10.4 mmol) of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-[1-(1-methoxy-1-methylethyl)-1,2,4-triazole-3-yl]propenone in 10.2 ml of a 2% aqueous solution of sulfuric acid and 30 ml of methanol were stirred at 60 $^{\circ}\text{C}$ for 1 hour. The solution was cooled and stirred at room temperature for 1 hour. A precipitated crystal was filtered off and washed
20 with 20 ml of 75% methanol to give 2.72 g of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propenone as a pale yellow crystal. Yield: 83.4%.

1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-

yl)propenone was prepared from a compound obtained in Example 11(2) - 11(5) after deprotection such as Example 12.

Example 13(1) A preparation of a crystal (type I) of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propenone.

712 g of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propenone was dissolved in 7 L of THF under heating. The obtained solution was filtered and washed with 2 L of THF. The obtained solution was concentrated under reduced pressure and 17 L of 99.5% EtOH was gradually added thereto. The solution was concentrated under reduced pressure to give 8.3 kg of the residue. The obtained slurry was stirred for 1 hour under water-cooling and filtered to give 548 g of a crystal (type I). According to single crystal X-ray diffraction, a crystal (type I) was a isomer having a chemical structure of the formula:



Elementary analysis for C₁₆H₁₂FN₃O₃.

Calcd (%): C, 61.34; H, 3.86; N, 13.41; F, 6.06.

Found (%): C, 61.22; H, 3.72; N, 13.41; F, 6.03.

Crystal parameters of single crystal X-ray diffraction

Unit cell constants: a = 32.432(2)Å

b = 10.886(2)Å

c = 7.960(2)Å

α = 90.00°

$$\beta = 90.00^\circ$$

$$\gamma = 90.00^\circ$$

$$V = 2810(1)\text{\AA}^3$$

$$Z = 8$$

5 Space group: Pbca

Density: 1.481 g/cm³

Diffraction angles (2 θ) and intensities of main peaks of powder X-ray diffraction of a crystal (type I)

Diffraction angle (2 θ)	Intensity
20.380	5945
21.280	5455
21.340	4958
23.140	4053
23.360	7218
23.540	8173
25.860	4615
27.460	4138
27.500	4068
28.100	5143
28.180	4980
29.400	4528
29.480	4848

10

Differential scanning calorimetry

Peak (°C)	ΔH (J/g)
185.831	149.181

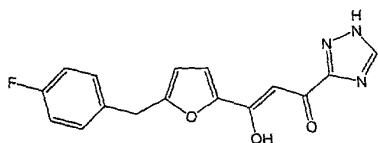
Example 13(2) A preparation of a crystal (type I) of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propenone.

15 4 g of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propenone was dissolved under heating in 21.2 ml of THF/H₂O (50:3). The obtained solution was filtered and 40 ml of THF/H₂O (3:94) 40ml was gradually added thereto. The obtained slurry was stirred for 1 hour under water-cooling, filtered and washed with water to give a crystal (type I). A

crystal obtained from this Example showed the same date of each instrumental analysis of a crystal (type I) obtained from Example 13(1).

Example 13(3) A preparation of a crystal (type II) of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propenone

2 g of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propenone was dissolved in 600 ml of ethylacetate under heating. The solution was filtered, kept standing at room temperature and dried under usual pressure. The obtained crystal was washed with ethylacetate to give a crystal (type II). Judging from a data of single crystal X-ray diffraction, a crystal (type II) was a isomer having a structure of the formula:



Crystal parameters of single crystal X-ray diffraction

Unit cell constants: $a = 11.9003(7)\text{\AA}$

$b = 9.7183(5)\text{\AA}$

$c = 13.2617(8)\text{\AA}$

$\alpha = 90.00^\circ$

$\beta = 109.450(4)^\circ$

$\gamma = 90.00^\circ$

$V = 1446.2(1)\text{\AA}^3$

$Z = 4$

Space group: $P2_1/n$

Density: 1.439 g/cm^3

Diffraction angles (2 θ) and intensities of main peaks of powder X-ray diffraction of a crystal (type II)

Diffraction angle (2 θ)	Intensity
8.760	12805
19.600	8023
22.080	8473
23.760	20195
26.200	33235
27.580	11623
29.080	4913

5 Differential scanning calorimetry

Peak ($^{\circ}$ C)	ΔH (J/g)
177.8	142.09
184.07	3.616

Example 13(4) A preparation of a crystal (III) of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propenone

To 1g of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-1,2,4-triazole-3-yl)propenone hydrochloride was added methanol (10 ml). After heating and stirring, methanol was concentrated under reduced pressure. Methanol (10ml) was added to the residue and concentrated as well as the above again. Moreover, methanol (10ml) was added to the residue and concentrated as well as the above again. The obtained slurry was kept standing overnight. A crystal was isolated and washed with methanol to give a crystal (type III).

Elementary analysis for C₁₆H₁₂FN₃O₃

Calcd: C, 61.43; H, 3.86; F, 6.06; N, 13.41; Cl 0.00.

20 Found: C, 60.23; H, 3.98; F, 5.85; N, 13.38; Cl <0.10.

Diffraction angles (2θ) and intensities of main peaks of powder X-ray diffraction of a crystal (type III)

Diffraction angle (2θ)	Intensity
10.520	4020
13.860	10368
15.680	11768
18.160	4363
22.840	6723
26.180	6335
28.120	3928

Differential scanning calorimetry

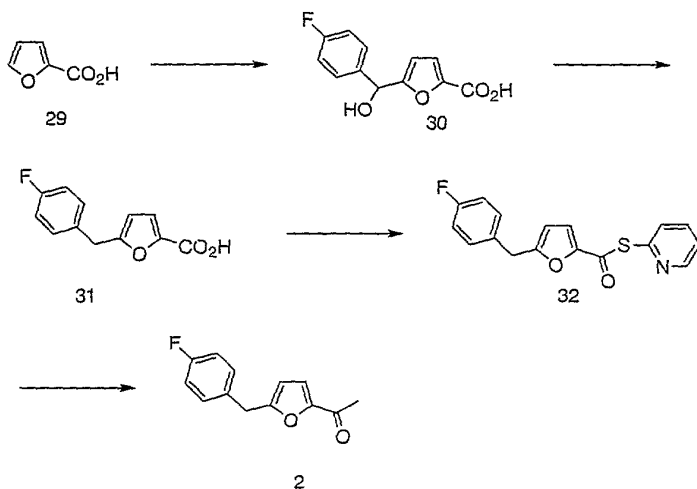
Peak ($^{\circ}\text{C}$)	ΔH (J/g)
130.8	-9.116
186.13	144.3

5

Another process for the preparation of 2-acetyl-5-(4-fluorobenzyl)furan are described below.

Example 14(1) A process for the preparation of 2-acetyl-5-(4-fluorobenzyl)furan (Another route 1)

10



(1) 5.6 g (50 mmol) of 2-furancarboxylic acid was reacted with 6.8 g (55 mmol) of 4-fluorobenzaldehyde in accordance with Tetrahedron Letters, 1979, 51, p469. The obtained crude crystal was washed with isopropyl ether to give 8.1 g

of 5-[[1-(4-fluorophenyl)-1-hydroxy]methyl]-furan-2-carboxylic acid. Yield: 69 %. Mp: 139-140 °C (decomposition).

NMR(CDCl₃) δ 5.88(1H, s), 6.28(1H, d, J=3.6Hz), 7.07(2H, t, J=8.7Hz), 7.25(1H, d, J=3.6Hz), 7.39-7.44(2H, m).

5 (2) 4.72 g (20 mmol) of the compound was reduced with 10.8 g (100 mmol) of trimethylchlorosilane and 15 g (100 mmol) of sodium iodide in accordance with Tetrahedron, 1995, 51, p11043 to give 3.52 g of 5-(4-fluorobenzyl)-furan-2-carboxylic acid as a crystal. Yield: 80 %.

10 NMR(d₆-DMSO) δ 4.05(2H, s), 6.31(1H, d, J=3.3Hz), 7.12-7.18(3H, m), 7.27-7.32(2H, m), 12.9(1H, brs).

(3) 3.52 g (16 mmol) of the above compound was reacted with 4.2 g (19.2 mmol) of dipyridyldisulfide and 5.04 g (19.2 mmol) of triphenylphosphine in accordance with Bull.Chem.Soc.Japan., 1974, 47, p1777 to give 3.7 g of 5-(4-fluorobenzyl)-furan-2-carboxylic acid 2-pyridylthioester. Yield: 77 %. Mp: 15 88-89 °C.

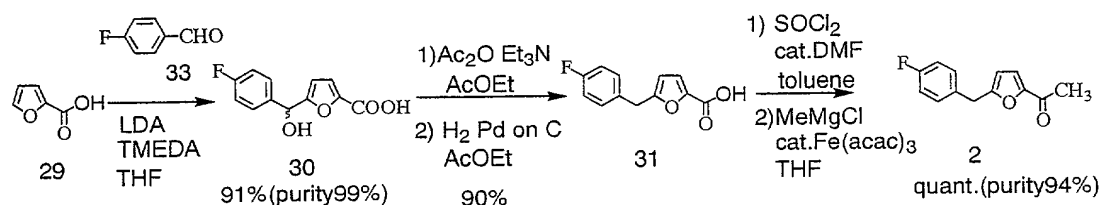
NMR(CDCl₃) δ 4.04(2H, s), 6.15(1H, d, J=3.3Hz), 7.03(2H, t, J=8.7Hz), 7.22(1H, d, J=3.3Hz), 7.22-7.26(2H, m), 7.29-7.34(1H, m), 7.70-7.79(2H, m), 8.63-8.66(1H, m).

(4) 3.7 g (12.4 mmol) of the above compound was reacted with 14 ml (1 M) 20 of methyl magnesium bromide in accordance with Bull.Chem.Soc.Japan., 1974, 47, p1777 to give 2.7 g of 2-acetyl-5-(4-fluorobenzyl)-furan as an oil(2.7 g) quantitatively.

NMR(CDCl₃) δ 2.43(3H, s), 4.01(2H, s), 6.10(1H, d, J=3.6Hz), 7.01(2H, t, J=9.0Hz), 7.10(1H, d, J=3.6Hz), 7.18-7.23(2H, m).

25

Example 14(2) A process for the preparation of 2-acetyl-5-(4-fluorobenzyl)furan (Another route 2)



(1) LDA in 27.5 ml (25% solution, 30mmol) of a mixed solution (THF/heptane/ethylbenzene) was cooled to -50°C and 7.5 ml (30 mmol) of tetramethylethylenediamine was added thereto. To the mixture was added
 5 with stirring under -45°C for 25 minutes 2.24 g (20 mmol) of 2-furancarboxylic acid in 12 ml of THF. After stirring for 1 hour at -50°C , 40 ml of THF was added to the obtained suspension. 3.8 ml (35 mmol) of 4-fluorobenzaldehyde was immediately added thereto. The reaction temperature rose from -50 to -15°C . After stirring under ice-cooling for 30
 10 minutes, 40 ml of water was added thereto. The organic layer was extracted with 1N sodium hydroxide aqueous solution. The obtained alkaline layer was washed with toluene, acidified with diluted hydrochloric acid and extracted with ethylacetate. The extract was washed with water, dried over anhydrous sodium sulfate and removed under reduced pressure. The
 15 obtained residue was crystallized from toluene and washed with cooled toluene to give a 4.29 g of hydroxy carboxylic acid. Yield: 91%.

(2) To a solution of 1.18 g (5 mmol) of hydroxy carboxylic acid and 1.52 g (15 mmol) of triethylamine in 15 ml of ethylacetate was added dropwise under ice-cooling a solution of 1.16 g (11.4 mmol) of acetic anhydride in 1 ml of
 20 ethylacetate. The solution was stirred under ice cooling for 30 minutes. 253 mg (2.5 mmol) of triethylamine and 180 mg of 10% palladium carbon were added thereto. The suspension was stirred at hydrogen atmosphere under usual pressure for 4.5 hours. The catalyst was filtered off. Dilute hydrochloric acid was added to the filtrate and extracted with ethylacetate.

The extract was washed with water, dried over anhydrous magnesium sulfate and removed under reduced pressure. The obtained residue was crystallized from n-hexane and washed with n-hexane to give 991 mg of carboxylic acid. Yield: 90%.

5 (3) To a suspension of 1.00 g (4.54 mmol) of carboxylic acid in 5 ml of toluene were added 648 mg (5.44 mmol) of thionylchloride and 0.03 ml of DMF. The suspension was stirred at 80 °C for 1.5 hours. The solvent and excess of thionylchloride were removed under reduced pressure, mixed with 5 ml of toluene and removed under reduced pressure. To the obtained residue were
10 added 10 ml of THF and 48 mg (0.12 mmol) of iron(III) acetylacetonate (Fe(acac)₃). The solution was cooled at -20 °C. To the solution was added dropwise for 10 minutes 1.75 ml (5.25 mmol) of 3M methyl magnesium chloride in THF with stirring at nitrogen atmosphere. The mixture was stirred at -20 °C for 30 minutes, mixed with diluted hydrochloric acid and
15 extracted with toluene. The extract was washed with water, washed with sodium hydrogencarbonate aqueous solution, washed with water and removed under reduced pressure to give 1.02 g of 2-acetyl-5-(4-fluorobenzyl)furan. Yield: quantitative.

20 The following compounds are prepared in accordance with the present process.

1-[5-(4-Fluorobenzyl)furan-2-yl]-3-hydroxy-3-(2*H*-tetrazole-5-yl)-
propenone

Mp: 121 - 123 °C. Recrystallized from ether.

25 Elementary analysis for C₁₅H₁₁FN₄O₃

Calcd (%): C, 57.33; H, 3.53; N, 17.83; F, 6.04.

Found (%): C, 57.25; H, 3.58; N, 17.53; F, 5.81.

NMR(d_6 -DMSO) δ 4.16(2H, s), 6.51(1H, d, $J=3.6$ Hz), 7.05(1H, s), 7.18(2H, t, $J=8.7$ Hz), 7.32-7.38(2H, m), 7.65(1H, d, $J=3.6$ Hz).

1-[5-(4-Fluorobenzyl)furan-2-yl]-3-hydroxy-3-(5-methyl-1*H*-

5 [1,2,4]triazole-3-yl)-propenone.

Mp: 179-182 °C. Recrystallized from ethylacetate.

Elementary analysis for $C_{17}H_{14}FN_3O_3$

Calcd (%): C, 62.38; H, 4.31; N, 12.84; F, 5.80.

Found (%): C, 62.29; H, 4.16; N, 11.65; F, 5.78.

10 NMR(d_6 -DMSO) δ 2.43(3H, s), 4.14(2H, s), 6.46(1H, d, $J=3.3$ Hz), 6.88(1H, s), 7.15-7.20(2H, m), 7.31-7.36(2H, m), 7.49(1H, d, $J=3.3$ Hz), 14.3(1H, brs).

1-[5-(4-Chlorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-[1,2,4]triazole-3-yl)-
propenone

15 Mp: 96-99 °C. Recrystallized from ethanol.

Elementary analysis for $C_{16}H_{12}ClN_3O_3$

Calcd (%): C, 58.28; H, 3.67; N, 12.74; Cl, 10.75.

Found (%): C, 58.16; H, 3.80; N, 12.40; Cl, 10.50.

20 NMR(d_6 -DMSO) δ 4.16(2H, s), 6.49(1H, d, $J=3.6$ Hz), 6.93(1H, s), 7.30-7.43(4H, m), 7.52(1H, d, $J=3.6$ Hz), 8.75(1H, brs).

1-(5-Benzylfuran-2-yl)-3-hydroxy-3-(1*H*-[1,2,4]triazole-3-yl)-propenone

Mp: 176-179 °C. Recrystallized from ethylacetate.

Elementary analysis for $C_{16}H_{13}N_3O_3 \cdot 0.15 C_4H_8O_2$

25 Calcd (%): C, 64.63; H, 4.64; N, 13.62.

Found (%): C, 64.41; H, 4.40; N, 13.42.

NMR(d_6 -DMSO) δ 4.14(2H, s), 6.48(1H, d, $J=3.6$ Hz), 6.93(1H, s), 7.24-7.38(5H, m),

7.51(1H, d, J=3.6Hz), 8.72(1H, brs), 14.7(1H, brs).

1-[[5-(4-Fluorobenzyl)-3-methyl]furan-2-yl]-3-hydroxy-3-(1*H*-[1,2,4]triazole-3-yl)-propenone.

5 Mp: 191-192 °C. Recrystallized from ethylacetate.

Elementary analysis for C₁₇H₁₄FN₃O₃

Calcd (%): C, 62.38; H, 4.31; N, 12.84; F, 5.80.

Found (%): C, 62.23; H, 4.29; N, 12.79; F, 5.79.

NMR(d₆-DMSO) δ 2.36(3H, s), 4.10(2H, s), 6.34(1H, s), 6.89(1H, s), 7.18(2H, t, J=9.0Hz), 7.32-7.37(2H, m), 8.70(1H, brs).

3-Hydroxy-1-[5-(4-methoxybenzyl)furan-2-yl]-3-(1*H*-[1,2,4]triazole-3-yl)-propenone.

Mp: 114-116 °C. Recrystallized from ethylacetate.

15 Elementary analysis for C₁₇H₁₅N₃O₄

Calcd (%): C, 62.76; H, 4.65; N, 12.92.

Found (%): C, 62.90; H, 4.57; N, 12.26.

NMR(d₆-DMSO) δ 3.73(3H, s), 4.07(2H, s), 6.44(1H, d, J=3.3Hz), 6.91(2H, d, J=8.7Hz), 6.92(1H, s), 7.22(2H, d, J=8.7Hz), 7.50(1H, d, J=3.3Hz), 8.77(1H, brs).

20 1-[5-(3-Fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-[1,2,4]triazole-3-yl)-propenone.

Mp: 140-143 °C. Recrystallized from ethanol.

Elementary analysis for C₁₆H₁₂FN₃O₃

25 Calcd (%): C, 61.34; H, 3.86; N, 13.41; F, 6.06.

Found (%): C, 61.41; H, 3.84; N, 13.05; F, 5.97.

NMR(d₆-DMSO) δ 4.19(2H, s), 6.52(1H, d, J=3.3Hz), 6.95(1H, s), 7.10-7.18(3H, m),

7.36-7.41(1H, m), 7.52(1H, d, J=3.3Hz), 8.77(1H, brs), 14.7(1H, brs).

1-[5-(2-Fluorobenzyl)furan-2-yl]-3-hydroxy-3-(1*H*-[1,2,4]triazole-3-yl)-
propenone

5 Mp: 182-184 °C. Recrystallized from ethanol/ether.

Elementary analysis for C₁₆H₁₂FN₃O₃

Calcd (%): C, 61.34; H, 3.86; N, 13.41; F, 6.06.

Found (%): C, 61.47; H, 3.90; N, 13.04; F, 5.99.

NMR(d₆-DMSO) δ 4.18(2H, s), 6.46(1H, d, J=3.3Hz), 6.94(1H, s), 7.17-7.26(2H, m),

10 7.32-7.40(2H, m), 7.51(1H, d, J=3.3Hz), 8.79(1H, brs).

3-Hydroxy-1-[5-(4-methylbenzyl)furan-2-yl]-3-(1*H*-[1,2,4]triazole-3-yl)-
propenone.

Mp: 166-167 °C. Recrystallized from ethylacetate.

15 Elementary analysis for C₁₇H₁₅N₃O₃ 0.1 C₄H₈O₂

Calcd (%): C, 65.69; H, 5.01; N, 13.21.

Found (%): C, 65.45; H, 4.93; N, 13.37.

NMR(d₆-DMSO) δ 2.28(3H, s), 4.09(2H, s), 6.46(1H, d, J=3.6Hz), 6.93(1H, s),

7.13-7.18(4H, m), 7.51(1H, d, J=3.6Hz), 8.76(1H, brs), 14.7(1H, brs).

20

HIV-1 integrase inhibitory activities of propenone derivatives were
examined in accordance with the following assay.

(1) Preparation of DNA solutions.

Substrate DNA and target DNA, which sequences were indicated below,
25 were synthesized by Amersham Pharmacia Biotech and dissolved in KTE
buffer (composition: 100 mM KCl, 1 mM EDTA, 10 mM Tris-HCl (pH 7.6)) at
concentration of 2 pmol/μl and 5 pmol/μl, respectively. The DNA solutions

were annealed with each complement by slowly cooling after heating.

(Substrate DNA)

5'- Biotin-ACC CTT TTA GTC AGT GTG GAA AAT CTC TAG CAG T-3'

3'- GAA AAT CAG TCA CAC CTT TTA GAG ATC GTC A-5'

5 (Target DNA)

5'- TGA CCA AGG GCT AAT TCA CT-Dig-3'

3'-Dig-ACT GGT TCC CGA TTA AGT GA -5'

(2) Calculations of the percent inhibitions (the IC₅₀ values of test compounds)

10 Streptavidin, obtained from Vector Laboratories, was dissolved in 0.1 M carbonate buffer (composition: 90 mM Na₂CO₃, 10 mM NaHCO₃) at concentration of 40 µg/ml. After coating each well of microtiter plates (obtained from NUNC) with 50 µl of the above solution at 4 °C over night, each well was washed twice with PBS (composition: 13.7 mM NaCl, 0.27 mM KCl, 0.43 mM Na₂HPO₄, 0.14 mM KH₂PO₄) and blocked with 300 µl of 1% skim milk in PBS for 30 min. Additionally, each well was washed twice with PBS and added 50 µl of substrate DNA solution (2 pmol/µl). The microtiter plates were kept at room temperature for 30 min. Then, each well was washed twice with PBS and once with H₂O.

20 Subsequently, in the each well prepared above were added 45 µl of the reaction buffer prepared from 12 µl of the buffer (composition: 150 mM MOPS (pH 7.2), 75 mM MnCl₂, 50 mM 2-mercaptoethanol, 25% glycerol, 500 µg/ml bovine serum albumin-fraction V), 1 µl of target DNA (5 pmol/µl), and 32 µl of the distilled water. Additionally, 6 µl of either a test compound in DMSO or
25 DMSO for positive control(PC) was mixed with the above reaction buffer, then 9 µl of an integrase solution (30 pmol) was added and mixed well. In the well of negative control (NC) was added 9 µl of the integrase dilution buffer

(composition: 20 mM MOPS (pH7.2), 400 mM potassium glutamate, 1 mM EDTA, 0.1% NP-40, 20% glycerol, 1 mM DTT, 4M urea).

The microtiter plates were incubated at 30 °C for 1 hour. The reaction solution was removed and each well was washed twice with PBS.

5 Subsequently, each well of the microtiter plates was filled with 100 µl of anti-digoxigenin antibody labeled with alkaline phosphatase (Sheep Fab fragment: obtained from Boehringer) and incubated at 30 °C for 1 hour.

Then, each well was washed twice with 0.05% Tween20 in PBS and once with PBS. Next, 150 µl of the Alkaline phosphatase reaction buffer (composition:

10 10mM *p*-Nitrophenylphosphate (obtained from Vector Laboratories), 5 mM MgCl₂, 100 mM NaCl, 100 mM Tris-HCl (pH 9.5)) was added in each well.

The microtiter plates were incubated at 30 °C for 2 hours and the reaction was terminated by the addition of 50 µl of 1 N NaOH solution. The optical density (OD) at 405 nm of each well was measured and the percent inhibition

15 was determined by the following expression.

The percent inhibition (%) = $100[1 - \{(C \text{ abs.} - NC \text{ abs.}) / (PC \text{ abs.} - NC \text{ abs.})\}]$

C abs. ; the OD of the well of the compounds

NC abs. : the OD of the negative control (NC)

20 PC abs. : the OD of the positive control (PC)

When the percent inhibition (%) is X% at the concentration of x µg/ml and the percent inhibition (%) is Y% at the concentration of y µg/ml, one of which is more than 50% and the other is less than 50%, IC₅₀ can be determined by the following expression.

25
$$IC_{50}(\mu\text{g/ml}) = x - \{(X-50)(x-y)/(X-Y)\}$$

The IC₅₀ values, the concentration of the compounds at percent inhibition 50%, are shown in the following Table 1.

Table

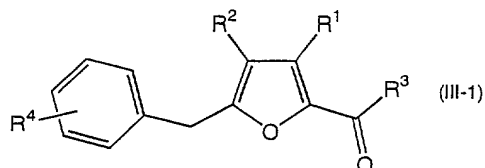
Compound No.	IC ₅₀ ($\mu\text{g}/\text{ml}$)
22	0.53

Industrial Applicability

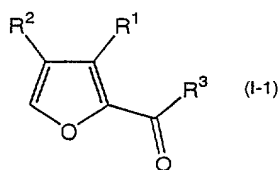
2-Acyl-5-benzylfuran derivatives can be industrially and commercially prepared through Friedel Crafts reaction of 2-acylfuran derivatives. The present invention provides an industrial process for the preparation of 1,2,4-triazole-3-carboxylic acid ester derivatives. These processes can contribute to stable mass-production of an integrase inhibitor, an anti-HIV agent, or a compound (IV-1) or (IV-2).

CLAIMS

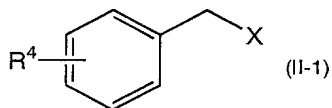
1. A process for the preparation of a compound of the formula (III-1):



- 5 wherein R¹ and R² each is independently hydrogen, optionally substituted alkyl, optionally substituted alkoxy or halogen; R³ is optionally substituted alkyl or optionally substituted alkoxy; and R⁴ is hydrogen, optionally substituted alkyl, optionally substituted alkoxy or halogen, which comprises reacting a compound of the formula (I-1):

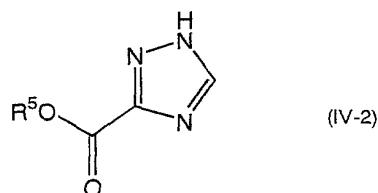


- 10 wherein R¹, R² and R³ each is as defined above, with a compound of the formula (II-1):



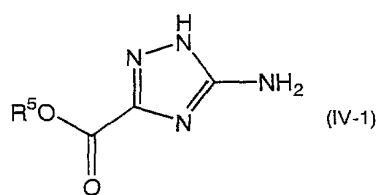
- 15 wherein R⁴ is as defined above; and X is halogen, in the presence of a Lewis acid.
2. The process according to claim 1 wherein a reaction solvent is methylene chloride.
3. The process according to claim 1 wherein a reaction solvent is water.
4. The process according to any one of claims 1-3 wherein R³ is methyl.
- 20 5. The process according to any one of claims 1-4 wherein R¹ and R² each is hydrogen.
6. The process according to any one of claims 1-5 wherein R⁴ is 4-fluoro.

7. A process for the preparation of a compound of the formula (IV-2):



wherein R⁵ is hydrogen or optionally substituted alkyl,

which comprises reacting a compound of the formula (IV-1):



wherein R⁵ is as defined above,

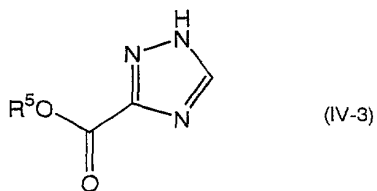
with an alkaline metal nitrite or an alkaline-earth metal nitrite in the presence of a reducing agent.

8. The process according to claim 7 which comprises reacting a compound of the formula (IV-1) with an alkaline metal nitrite in the presence of hypophosphorous acid as the reducing agent.

9. The process according to claim 7 or 8 which is carried out under the addition of a small amount of alcohol.

10. The process according to any one of claims 7-9 wherein R⁵ is hydrogen.

11. A process for the preparation of a compound of the formula (IV-3):

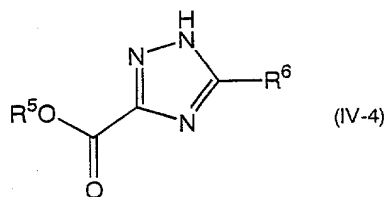


wherein R⁵ is optionally substituted alkyl,

which comprises preparing 1,2,4-triazole-3-carboxylic acid through the

process according to claim 10 and esterifying the obtained compound,

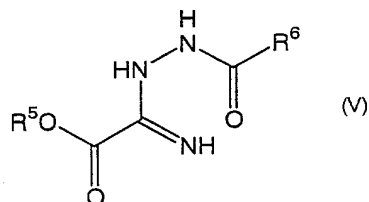
12. A process for a compound of the formula (IV-4):



wherein R⁵ is hydrogen or optionally substituted alkyl; and R⁶ is hydrogen,

5 optionally substituted alkyl or optionally substituted aryl,

which comprises cyclizing a compound of the formula (V):



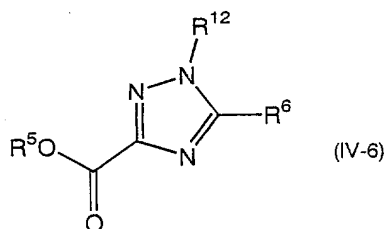
wherein R⁵ and R⁶ are as defined above,

in the presence of trialkylorthoester or a catalytic amount of an acid.

10 13. The process according to claim 12 wherein R⁵ is optionally substituted alkyl.

14. The process according to claim 12 wherein R⁵ is optionally substituted alkyl; and R⁶ is hydrogen.

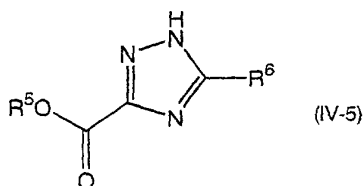
15. A process for the preparation of a compound of the formula (IV-6):



wherein R⁵ is optionally substituted alkyl; R⁶ is hydrogen, optionally substituted alkyl or optionally substituted aryl; and R¹² is a group of the formula: -R⁷ wherein R⁷ is trityl, optionally substituted sulfamoyl or

optionally substituted alkoxymethyl, a group of the formula: $-C(OR^8)R^9-CHR^{10}R^{11}$ wherein R^8 is optionally substituted alkyl; R^9 , R^{10} and R^{11} each is independently hydrogen or optionally substituted alkyl; or R^8 and R^{10} may be taken together to form optionally substituted alkylene, or hydroxymethyl,

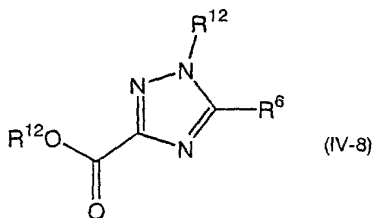
5 which comprises preparing a compound of the formula (IV-5):



wherein R^5 and R^6 are as defined above, through the process according to any one of claims 7-9 and 11-14, and reacting the obtained compound with a compound of the formula: R^7X wherein R^7 is as defined above; and X is halogen,

10 a compound of the formula: $(R^8O)R^9C=CR^{10}R^{11}$ wherein R^8 , R^9 , R^{10} and R^{11} are as defined above, or formaldehyde.

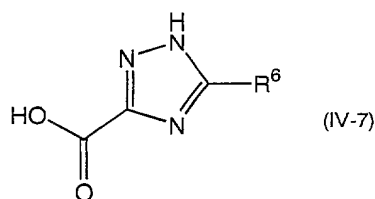
16. A process of the preparation of a compound of the formula (IV-8):



wherein R^6 is hydrogen, optionally substituted alkyl or optionally substituted aryl; and R^{12} is a group of the formula: $-R^7$ wherein R^7 is trityl, optionally substituted sulfamoyl or optionally substituted alkoxymethyl, a group of the formula: $-C(OR^8)R^9-CHR^{10}R^{11}$ wherein R^8 is optionally substituted alkyl; R^9 , R^{10} and R^{11} each is independently hydrogen or optionally substituted alkyl, or R^8 and R^{10} may be taken together to form optionally substituted alkylene, or

15 hydroxymethyl, which comprises preparing a compound of the formula (IV-7):

20



wherein R^6 is as defined above, through the process according to claim 10 or 12, and reacting the obtained compound with a compound of the formula: R^7X wherein R^7 is as defined above; and X is halogen, a compound of the formula:

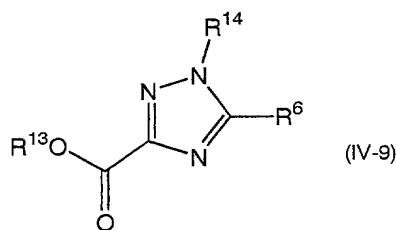
5 $(R^8O)R^9C=CR^{10}R^{11}$ wherein R^8 , R^9 , R^{10} and R^{11} are as defined above, or formaldehyde.

17. The process according to claim 15 or 16 which comprises reacting with a compound of the formula: R^7X wherein R^7 is trityl.

18. The process according to claim 15 or 16 which comprises reacting with a compound of the formula: $(R^8O)R^9C=CR^{10}R^{11}$ wherein R^8 and R^{10} are taken together to form trimethylene; and R^9 and R^{11} each is hydrogen.

19. The process according to claim 15 or 16 which comprises reacting with a compound of the formula: $(R^8O)R^9C=CR^{10}R^{11}$ wherein R^8 and R^9 each is methyl; and R^{10} and R^{11} each is hydrogen.

20. A compound of the formula (IV-9):



wherein R^6 is hydrogen or alkyl; R^{13} is alkyl, a group of the formula: $-R^7$ wherein R^7 is trityl, optionally substituted sulfamoyl or alkoxymethyl, a group of the formula: $-C(OR^8)R^9-CHR^{10}R^{11}$ wherein R^8 is alkyl; R^9 , R^{10} and R^{11} each is independently hydrogen or alkyl; or R^8 and R^{10} may be taken together to form alkylene, or hydroxymethyl; and R^{14} is a group of the formula: $-R^7$

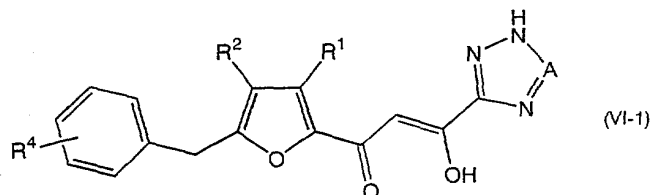
wherein R^7 is as defined above, a group of the formula: $-C(OR^8)R^9-CHR^{10}R^{11}$

wherein R^8 , R^9 , R^{10} and R^{11} are defined above, or hydroxymethyl,

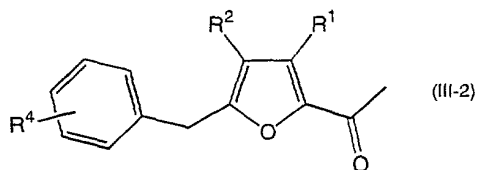
provided that a compound wherein R^6 is hydrogen; R^{13} is methyl; and R^{14} is trityl, a compound wherein R^6 is hydrogen; R^{13} is methyl; and R^{14} is tetrahydropyran-2-yl, and a compound wherein R^6 is hydrogen; R^{13} is ethyl; and R^{14} is trityl are excluded.

21. The compound according to claim 20 wherein R^6 is hydrogen; R^{13} is methyl or ethyl; R^{14} is tetrahydropyran-2-yl, hydroxymethyl, methoxymethyl, ethoxymethyl, N,N-dimethylsulfamoyl, (1-methoxy-1-methyl)ethyl, (1-ethoxy)ethyl, (1-ethoxy-1-methyl)ethyl, (1-n-propoxy)ethyl, (1-n-butoxy)ethyl or (1-isobutoxy)ethyl.

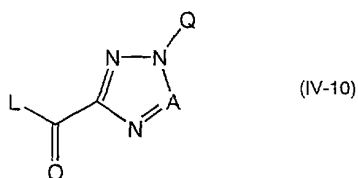
22. A process for the preparation of a compound of the formula (VI-1):



wherein R^1 , R^2 and R^4 each is independently hydrogen, optionally substituted alkyl, optionally substituted alkoxy or halogen; A is CR^6 or N; and R^6 is hydrogen, optionally substituted alkyl or optionally substituted aryl, which comprises preparing a compound of the formula (III-2):



wherein R^1 , R^2 and R^4 are as defined above, through the process according to claim 4, reacting the compound of the formula (III-2) with a compound of the formula (IV-10):



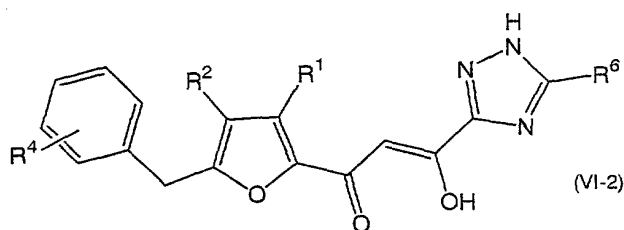
wherein A is as defined above, Q is a protecting group; and L is a leaving group, in the presence of a base, and deprotecting Q.

23. The process according to claim 22 wherein R¹ and R² each is hydrogen;
5 and R⁴ is halogen.

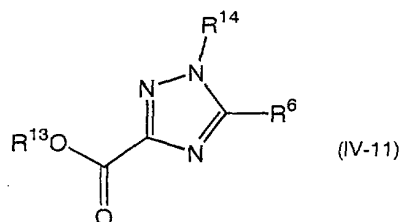
24. The process according to claim 22 or 23 wherein R⁴ is 4-fluoro.

25. The process according to any one of claims 22-24 wherein A is CH.

26. A process for the preparation of a compound of the formula (IV-2):



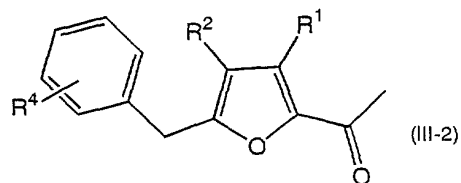
10 wherein R¹, R² and R⁴ each is independently hydrogen, optionally substituted alkyl, optionally substituted alkoxy or halogen; and R⁶ is hydrogen, optionally substituted alkyl or optionally substituted aryl, which comprises preparing a compound of the formula (IV-11):



15 wherein R⁶ is as defined above, R¹³ is optionally substituted alkyl, a group of the formula: -R⁷ wherein R⁷ is trityl, optionally substituted sulfamoyl or optionally substituted alkoxymethyl, a group of the formula: -C(OR⁸)R⁹-CHR¹⁰R¹¹ wherein R⁸ is alkyl; R⁹, R¹⁰ and R¹¹ each is independently hydrogen or optionally substituted alkyl; or R⁸ and R¹⁰ may be taken together to form

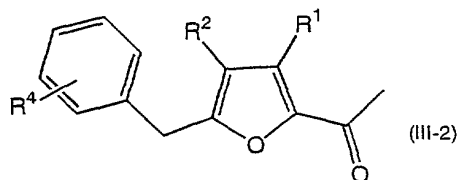
alkylene, or hydroxymethyl; and R^{14} is a group of the formula: $-R^7$ wherein R^7 is as defined above, a group of the formula: $-C(OR^8)R^9-CHR^{10}R^{11}$ wherein R^8 , R^9 , R^{10} and R^{11} are defined above, or hydroxymethyl, through the process according to claim 15 or 16, reacting the obtained compound with a compound

5 of the formula(III-2):



wherein R^1 , R^2 and R^4 are as defined above, and deprotecting R^{14} ,

27. The process according to claim 26 which comprises preparing the compound of the formula (III-2):

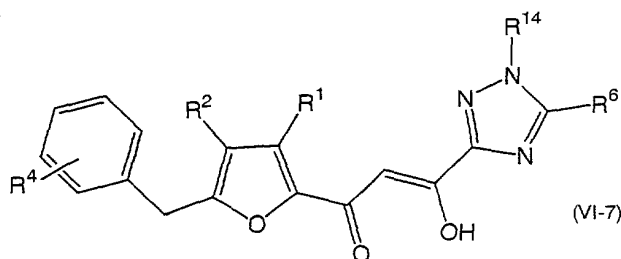


wherein R^1 , R^2 and R^4 each is independently hydrogen, optionally substituted alkyl, optionally substituted alkoxy or halogen through the process according to claim 4.

28. The process according to claim 26 or 27 wherein R^1 , R^2 and R^6 each is

15 hydrogen; and R^4 is halogen.

29. A compound of the formula (VI-7):

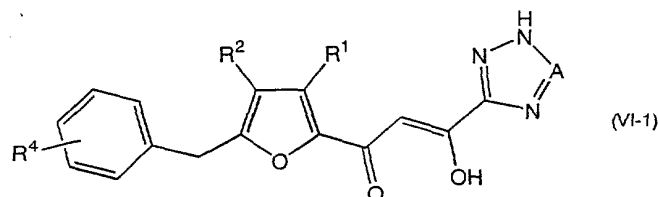


wherein R^1 , R^2 and R^4 each is independently hydrogen, optionally substituted alkyl, optionally substituted alkoxy or halogen; R^6 is hydrogen, optionally

substituted alkyl or optionally substituted aryl; and R¹⁴ is a group of the formula: -R⁷ wherein R⁷ is trityl, optionally substituted sulfamoyl or optionally substituted alkoxymethyl, a group of the formula: -C(OR⁸)R⁹-CHR¹⁰R¹¹ wherein R⁸ is alkyl; R⁹, R¹⁰ and R¹¹ each is independently hydrogen or optionally substituted alkyl; or R⁸ and R¹⁰ may be taken together to form alkylene, or hydroxymethyl.

30. The compound according to claim 29 wherein R⁴ is 4-fluoro, R¹, R² and R⁶ each is hydrogen, and R¹⁴ is trityl, tetrahydropyran-2-yl, hydroxymethyl, methoxymethyl, ethoxymethyl, N,N-dimethylsulfamoyl, (1-methoxy-1-methyl)ethyl, (1-ethoxy)ethyl, (1-ethoxy-1-methyl)ethyl, (1-n-propoxy)ethyl, (1-n-butoxy)ethyl or (1-isobutoxy)ethyl.

31. A crystal of an isomer having a chemical structure of the formula (VI-1):



wherein A is CR⁶ or N; R⁶ is hydrogen, optionally substituted alkyl or optionally substituted aryl; and R¹, R² and R⁴ each is independently hydrogen, optionally substituted alkyl, optionally substituted alkoxy or halogen.

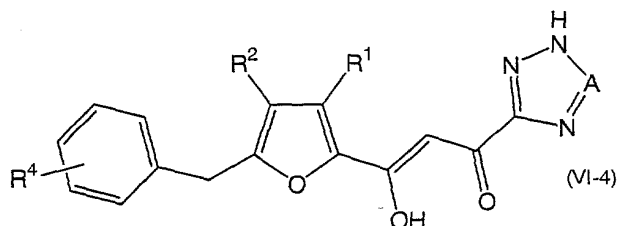
32. The crystal according to claim 31 wherein R¹ and R² each is hydrogen; R⁴ is p-fluoro; and A is CH.

33. The crystal according to claim 32 of which crystal parameters by single crystal X-ray diffraction are unit cell constants a = 32.432(2) Å, b = 10.886(2) Å, c = 7.960(2) Å, α = 90.00°, β = 90.00°, γ = 90.00°, V = 2810(1) Å³, Z = 8, a space group Pbca; and density of 1.481 g/cm³.

34. The crystal according to claim 32 of which diffraction angles (2θ) of main peaks by powder X-ray diffraction are 20.380, 21.280, 21.340, 23.140, 23.360,

23.540, 25.860, 27.460, 27.500, 28.100, 28.180, 29.400 and 29.480 (degree).

35. A crystal of an isomer having a chemical structure of the formula (VI-4):



wherein A is CR⁶ or N; R⁶ is hydrogen, optionally substituted alkyl or
5 optionally substituted aryl; and R¹, R² and R⁴ each is independently hydrogen,
optionally substituted alkyl, optionally substituted alkoxy or halogen.

36. The crystal according to claim 35 wherein R¹ and R² each is hydrogen; R⁴
is p-fluoro; and A is CH.

37. The crystal according to claim 36 of which crystal parameters by single
10 crystal X-ray diffraction are unit cell constants $a = 11.9003(7)\text{\AA}$, $b = 9.7183(5)\text{\AA}$, $c = 13.2617(8)\text{\AA}$, $\alpha = 90.00^\circ$, $\beta = 109.450(4)^\circ$, $\gamma = 90.00^\circ$, $V = 1446.2(1)\text{\AA}^3$ and $Z = 4$; a space group $P2_1/n$; and density of 1.439 g/cm^3 .

38. The crystal according to claim 36 of which diffraction angles (2θ) of main
peaks by powder X-ray diffraction are 8.760, 19.600, 22.080, 23.760, 26.200,
15 27.580 and 29.080 (degree).

39. A crystal of an isomer of 1-[5-(4-fluorobenzyl)furan-2-yl]-3-hydroxy-3-
(1H-1,2,4-triazole-3-yl)propenone of which diffraction angles (2θ) of main
peaks by powder X-ray diffraction are 10.520, 13.860, 15.680, 18.160, 22.840,
26.180 and 28.120 (degree).

Figure 1

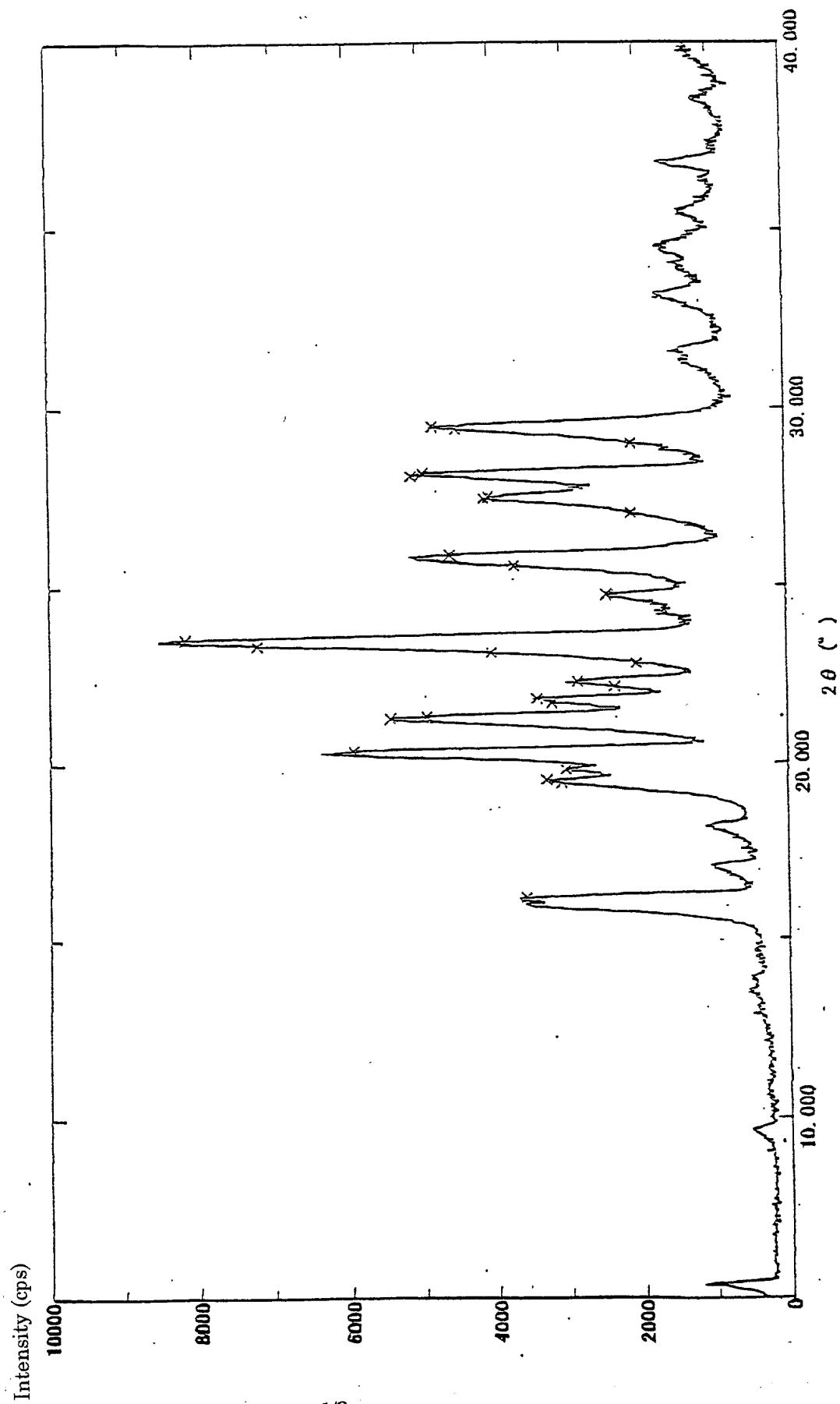


Figure 2

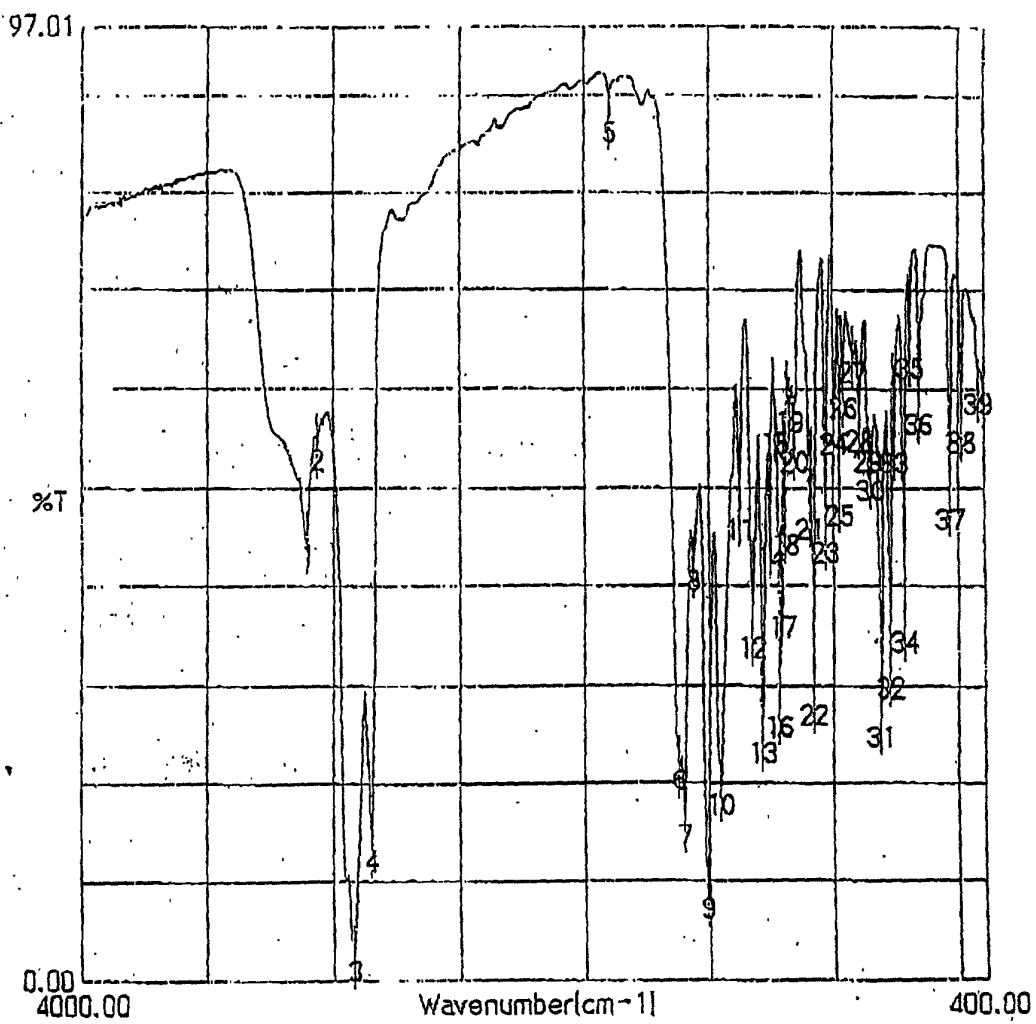


Figure 3

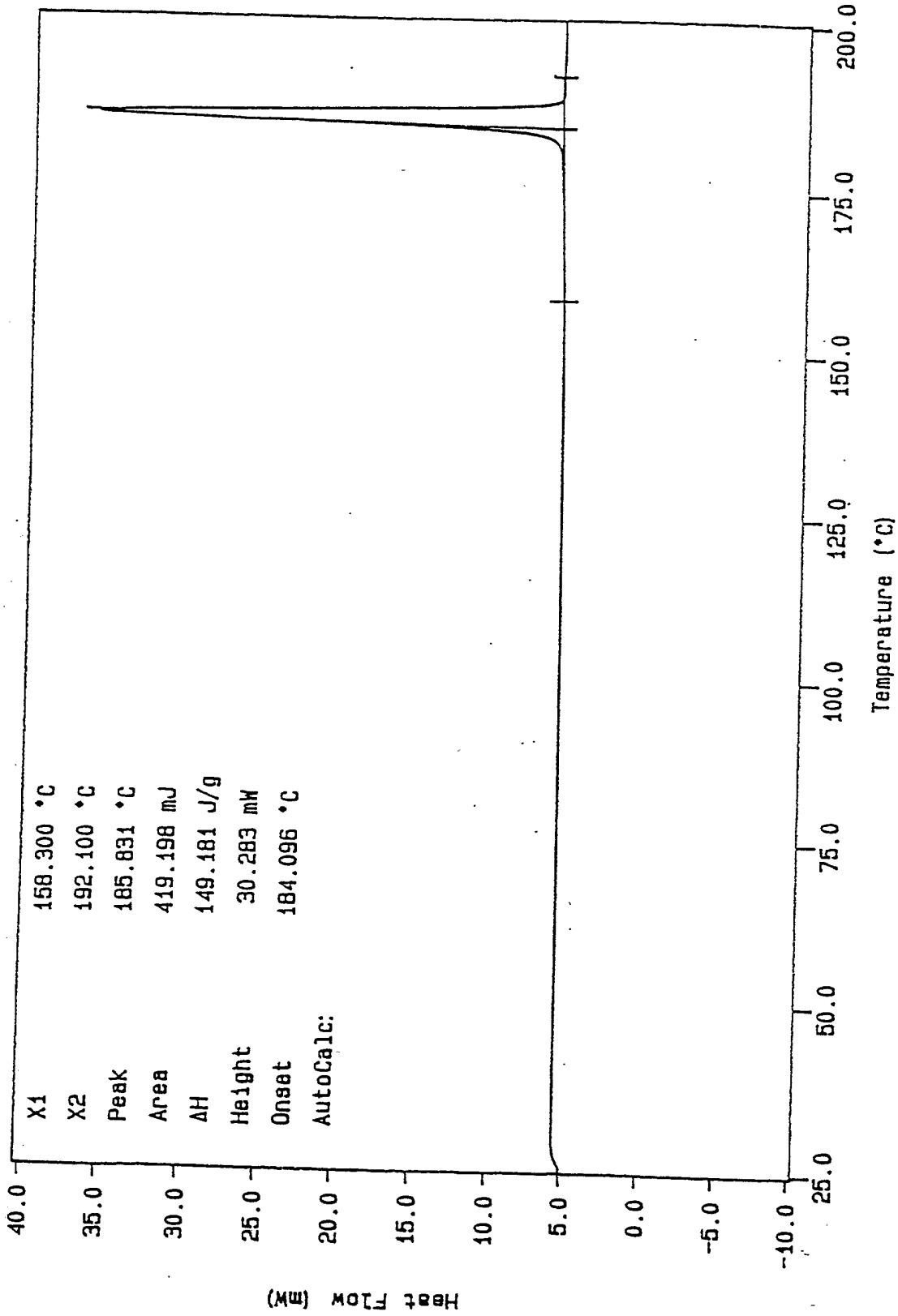


Figure 4

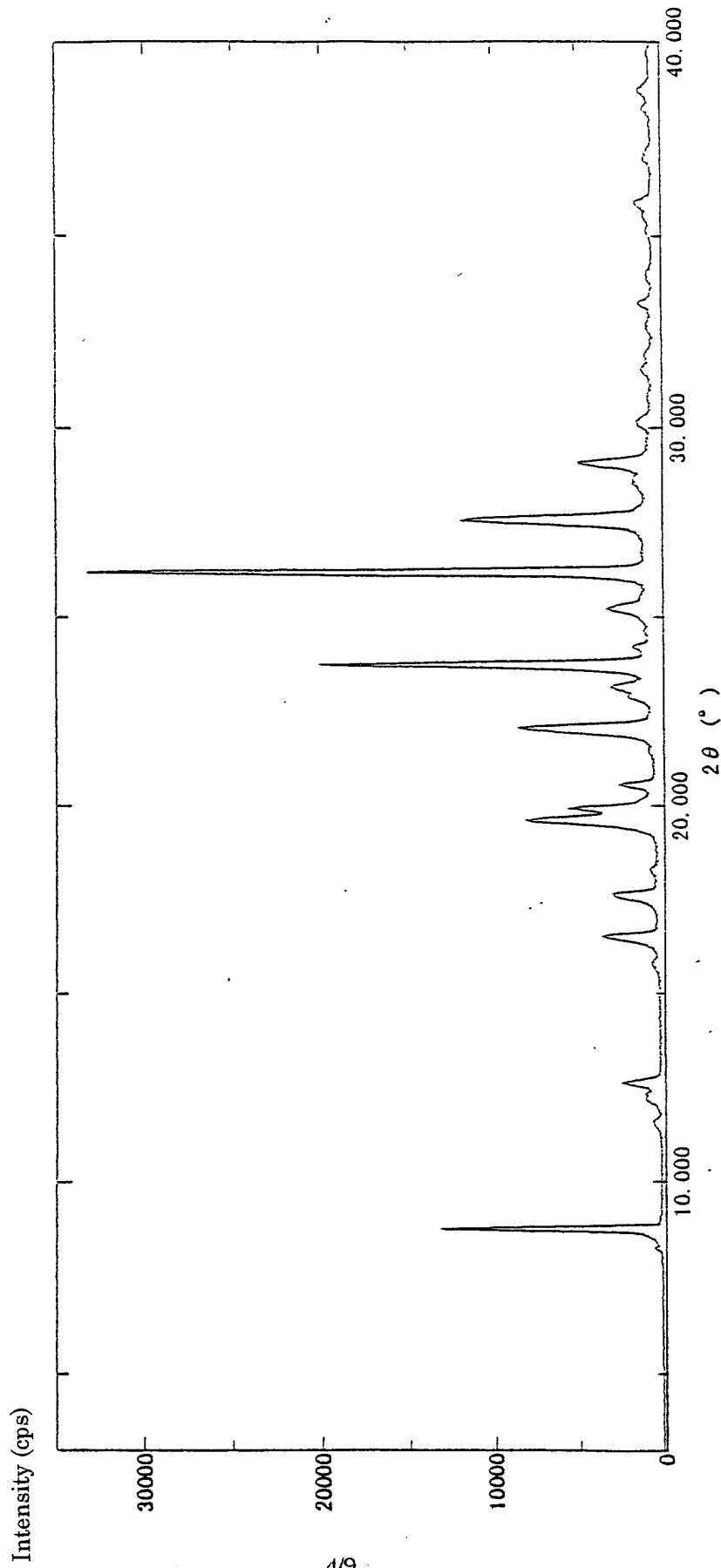


Figure 5

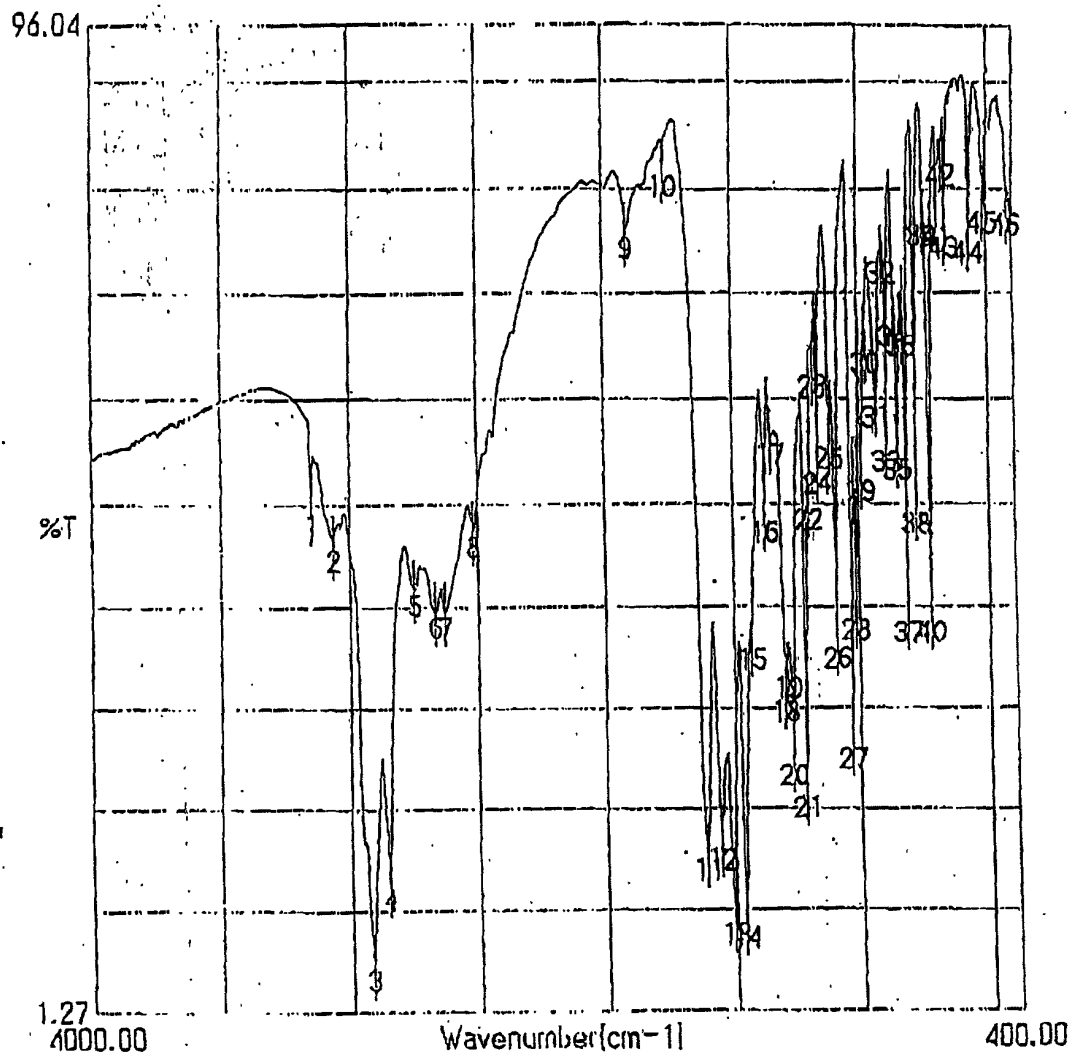


Figure 6

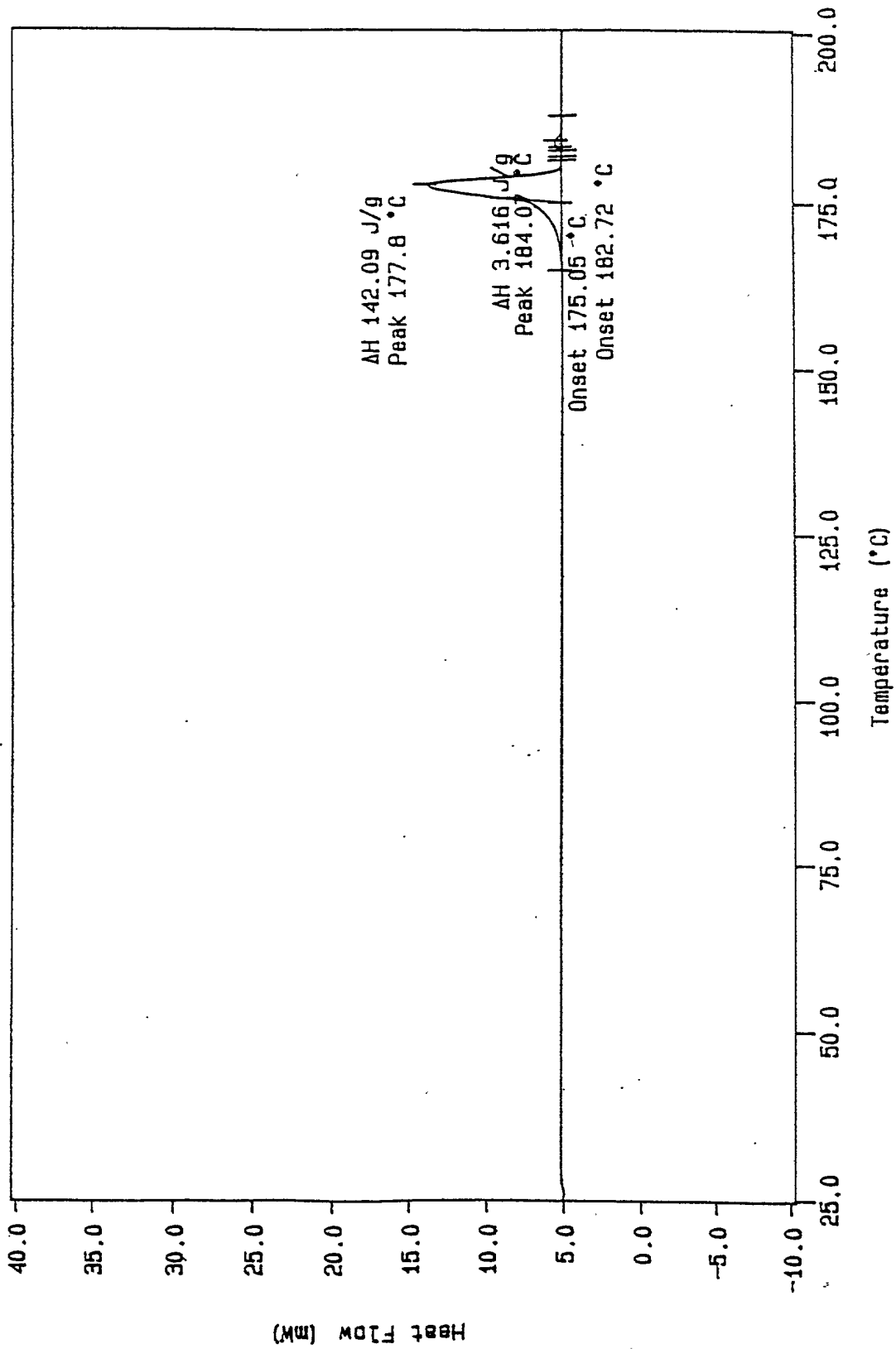


Figure 7

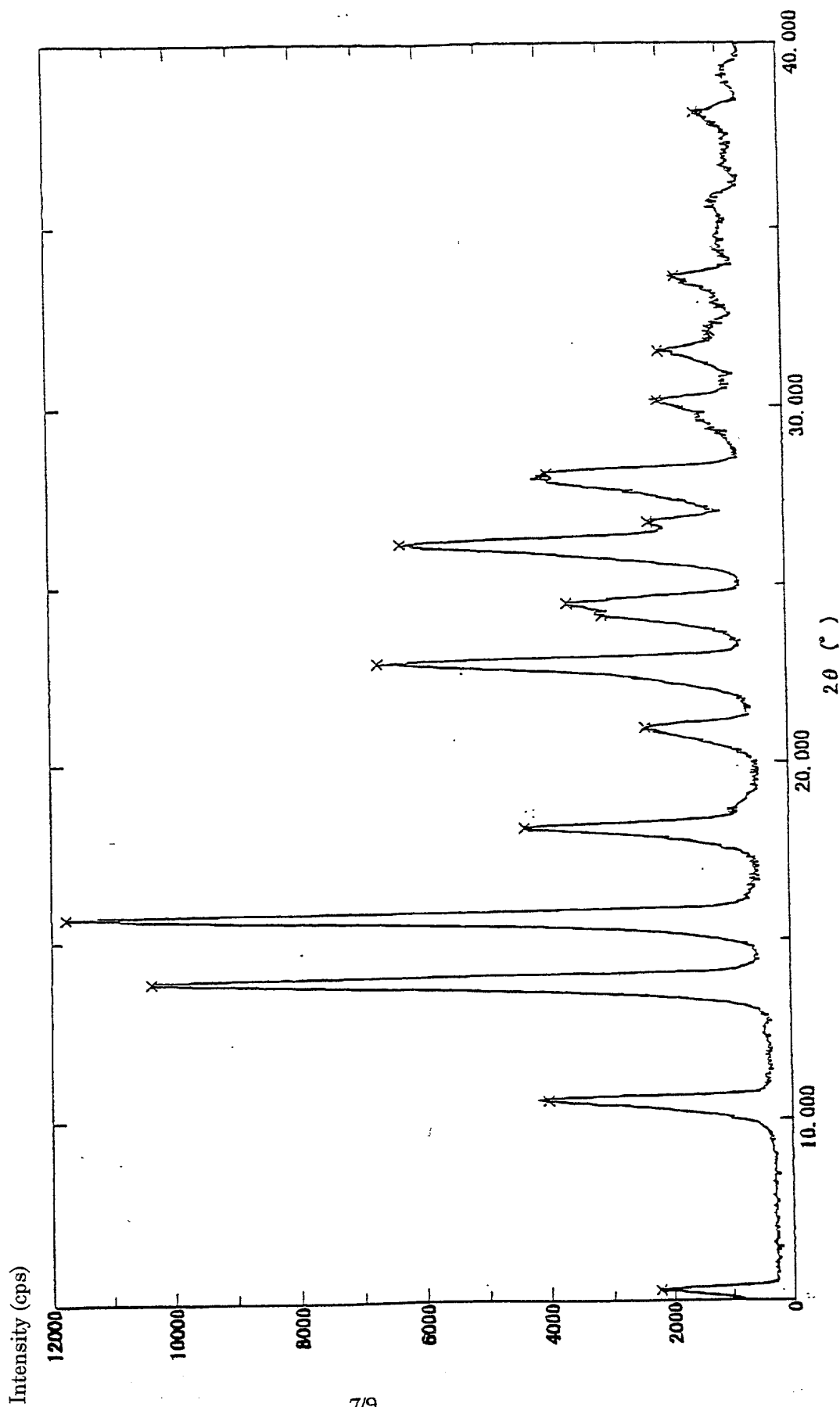


Figure 8

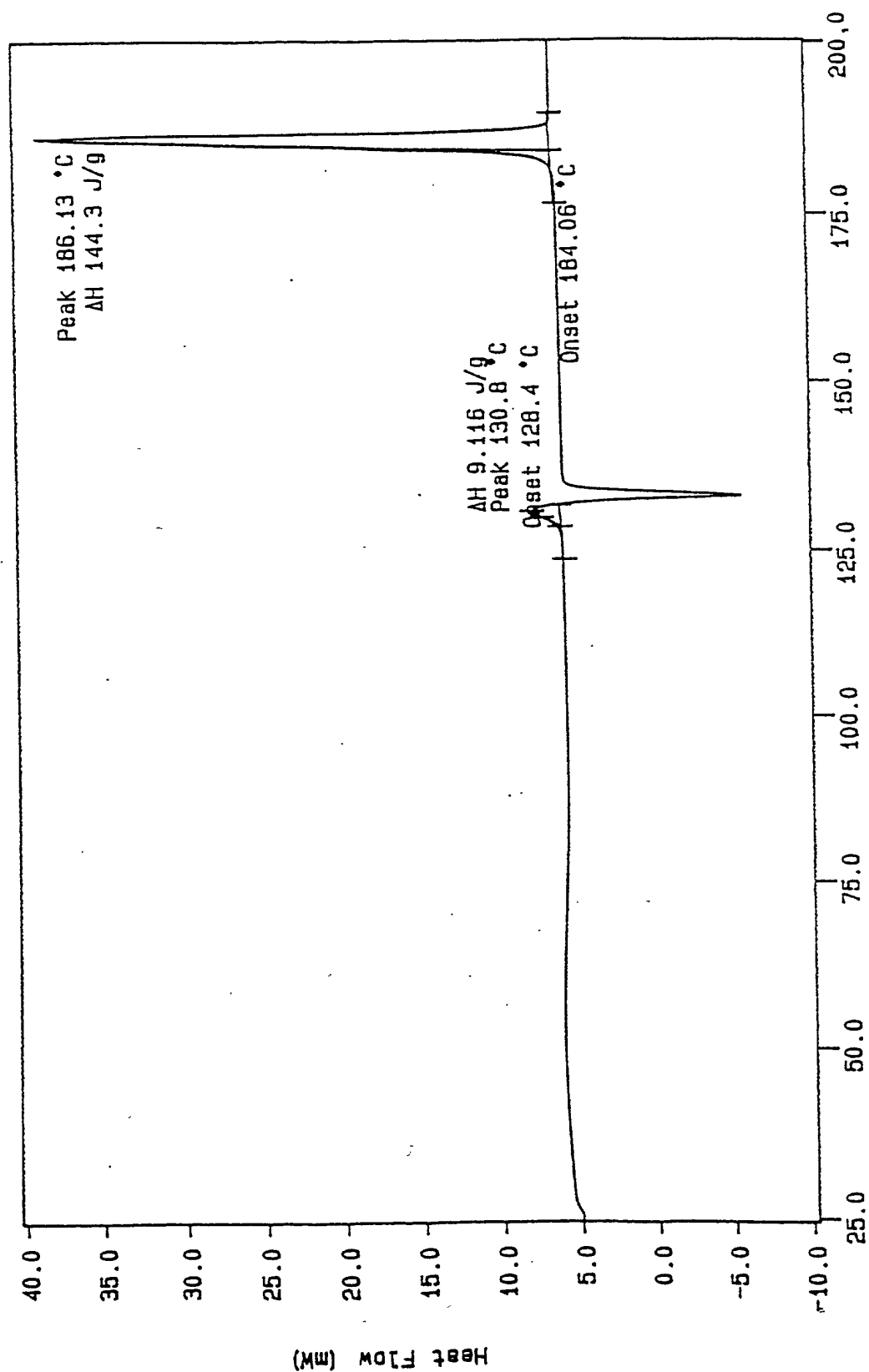
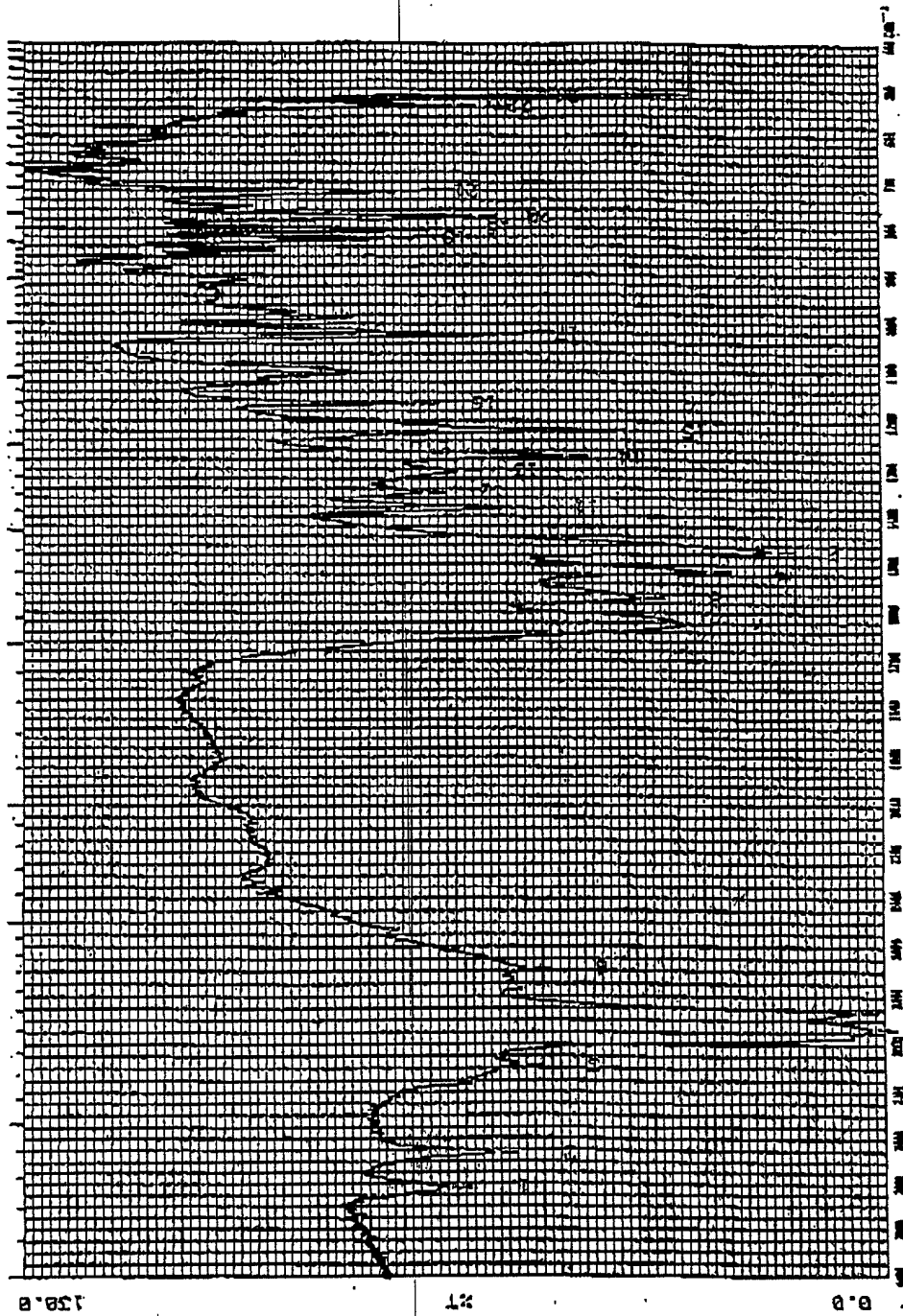


Figure 9



DECLARATION AND POWER OF ATTORNEY FOR U.S. PATENT APPLICATION

☐ Original ☐ Supplemental ☐ Substitute ☐ PCT ☐ Design

As a below named inventor, I hereby declare that: my residence, post office address and citizenship are as stated below next to my name; that I verily believe that I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural inventors are named below) of the subject matter which is claimed and for which a patent is sought on the invention entitled:

Title: PROCESSES FOR PREPARATION OF NOVEL SUBSTITUTED PROPENONE

DERIVATIVES

of which is described and claimed in:

- ☐ the attached specification, or
☐ the specification in the application Serial No. _____ filed _____;
 and with amendments through _____ (if applicable), or
☐ the specification in International Application No. PCT/ JP00/03456, filed May 29, and as amended
 on December 18, 2000 (if applicable).

I hereby state that I have reviewed and understand the content of the above-identified specification, including the claims, as amended by any amendment(s) referred to above.

I acknowledge my duty to disclose to the Patent and Trademark Office all information known to me to be material to patentability as defined in Title 37, Code of Federal Regulations, ' 1.56.

I hereby claim priority benefits under Title 35, United States Code, ' 119 (and ' 172 if this application is for a Design) of any application(s) for patent or inventor's certificate listed below and have also identified below any application for patent or inventor's certificate having a filing date before that of the application on which priority is claimed:

COUNTRY	APPLICATION NO.	DATE OF FILING	PRIORITY CLAIMED
Japan	155503/1999	June 2, 1999	Yes
Japan	230305/1999	August 17, 1999	Yes


I hereby claim the benefit under Title 35, United States Code ' 120 of any United States application(s) listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States application in the manner provided by the first paragraph of Title 35, United States Code ' 112, I acknowledge the duty to disclose information material to patentability as defined in Title 37, Code of Federal Regulations, ' 1.56 which occurred between the filing date of the prior application and the national or PCT international filing date of this application.

APPLICATION SERIAL NO.	U.S. FILING DATE	STATUS: PATENTED, PENDING, ABANDONED

And I hereby appoint Michael R. Davis, Reg. No. 25,134; Matthew M. Jacob, Reg. No. 25,154; Warren M. Cheek, Jr., Reg. No. 33,367; Nils Pedersen, Reg. No. 33,145; Charles R. Watts, Reg. No. 33,142; and Michael S. Huppert, Reg. No. 40,268, who together constitute the firm of WENDEROTH, LIND & PONACK, L.L.P., as well as any other attorneys and agents associated with Customer No. 000513, to prosecute

this application and to transact all business in the U.S. Patent and Trademark Office connected therewith.

I hereby authorize the U.S. attorneys and agents named herein to accept and follow instructions from _____, as to any action to be taken in the U.S. Patent and Trademark Office regarding this application without direct communication between the U.S. attorneys and myself. In the event of a change in the persons from whom instructions may be taken, the U.S. attorneys named herein will be so notified by me.

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Full Name of Fifth Inventor	FAMILY NAME	FIRST GIVEN NAME	SECOND GIVEN NAME
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Post Office Address	ADDRESS	CITY	STATE OR COUNTRY ZIP CODE

Full Name of Sixth Inventor	FAMILY NAME	FIRST GIVEN NAME	SECOND GIVEN NAME
Residence & Citizenship	CITY	STATE OR COUNTRY	COUNTRY OF CITIZENSHIP
Post Office Address	ADDRESS	CITY	STATE OR COUNTRY ZIP CODE

Full Name of Seventh Inventor	FAMILY NAME	FIRST GIVEN NAME	SECOND GIVEN NAME
Residence & Citizenship	CITY	STATE OR COUNTRY	COUNTRY OF CITIZENSHIP
Post Office Address	ADDRESS	CITY	STATE OR COUNTRY ZIP CODE

I further declare that all statements made herein of my own knowledge are true, and that all statements on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code, and that such willful false statements may jeopardize the validity of the application or any patent issuing thereon.

1st Inventor Masaaki Uenaka Date Nov. 14, 2001
2nd Inventor Kyozo Kawata Date Nov. 16, 2001
3rd Inventor Masahiko Nagai Date Nov. 14, 2001
4th Inventor Takeshi Endoh Date Nov. 15, 2001
5th Inventor _____ Date _____
6th Inventor _____ Date _____
7th Inventor _____ Date _____

The above application may be more particularly identified as follows:

U.S. Application Serial No. _____ Filing Date _____
Applicant Reference Number _____ Atty Docket No. _____
Title of Invention _____